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United States Department of Agriculture

Food Safety and Inspection Service

March 5, 1986, thru
April 30, 1986.

Compilation of Meat and Poultry Inspection Issuances

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The period covered in this Issuance is March 5, 1986, through April 30, 1986.

UNITED STATES DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
WASHINGTON, D. C.

FSIS NOTICE

12-86 | 4-16-86

IRRADIATION OF PORK FOR CONTROL OF TRICHINELLA SPIRALLIS

I. PURPOSE

This notice provides interim operating guidance concerning the use of gamma radiation to control trichina in pork.

II. APPROVAL OF IRRADIATION FOR PORK

The Food Safety and Inspection Service has recently approved the use of 30-100 krad gamma irradiation for trichina control in pork carcasses and fresh (unfrozen), non-heat-processed cuts of pork (Attachment 1). Specifics on labeling, facilities, equipment, quality control, and trichina certification requirements will be developed through notice and comment rulemaking in the near future. Until such time as these regulations are promulgated, FSIS will follow the attached operational guidelines (Attachments 2, 3, and 4). These guidelines are temporary and subject to change with the development of regulations.

III. LIMITATIONS

Irradiation is not included in regulations which prescribe mandatory treatments of pork to destroy trichina (9 CFR 318.10(c)). Irradiation **may not** be used in lieu of the trichina destruction procedures contained in that section of the regulations. Additionally, irradiated pork **may not** be used in the products listed under 9 CFR 318.10(b), or in any other foods that are prepared in such a manner that the product might be eaten rare or without thorough cooking, unless the irradiated pork is subsequently frozen, cooked, or cured to destroy possible live trichina.

DISTRIBUTION:	**NOTICE EXPIRES:**	**OPI:**
All Washington Offices; All Field Offices; All Inspection Offices and Plant Management	4-16-87	MPITS: Standards and Labeling Division

IV. QUESTIONS REGARDING THIS NOTICE

Direct any questions regarding this notice to the Regional Office.

RJ Prucha

Deputy Administrator
Meat and Poultry Inspection Operations

Attachments

1 Irradiation of Pork for Control of **Trichinella spiralis**
2 Labeling of Irradiated Pork and Products Containing Irradiated Pork
3 Partial Quality Control (PQC) Program Guidelines for Establishments Which Irradiate Fresh (Uncured), Non-frozen or Previously Frozen and Thawed Boxed Pork
4 Partial Quality Control (PQC) Program Guidelines for Establishments Which Package and Ship Pre-Labeled Pork to an Official Irradiation Facility

Food Safety and Inspection Service

9 CFR Part 318

[Docket No. 85-061F]

Irradiation of Pork for Control of Trichinella Spiralis

AGENCY: Food Safety and Inspection Service, USDA.

ACTION: Final rule.

SUMMARY: The Food Safety and Inspection Service is amending the Federal meat inspection regulation to permit the use of gamma radiation for control of *Trichinella spiralis* in fresh or previously frozen pork. This action follows a final rule published by the Food and Drug Administration (FDA) in the Federal Register of July 22, 1985 (50 FR 29658). The FDA final rule amended that agency's regulations to permit the use of gamma radiation sources with a minimum absorbed dose of 0.3 kiloGray (30 kilorads) to a maximum absorbed dose not to exceed 1 kiloGray (100 kilorads) for treatment of pork carcasses or fresh, non-heat-processed cuts of pork carcasses to control *Trichinella spiralis*.

EFFECTIVE DATE: January 15, 1986; See also "Rationale for Issuing a Final Rule".

ADDRESS: Post-promulgation comments concerning this final rule may be addressed to the Department of Agriculture, Food Safety and Inspection Service, ATTN: Hearing Clerk, 14th and Independence S.W., Washington, DC 20250 (202-447-8545). (See also "Comments" under "**SUPPLEMENTARY INFORMATION.**")

FOR FURTHER INFORMATION CONTACT: Ms. Margaret O'K. Glavin, Director, Standards and Labeling Division, Meat and Poultry Inspection Technical Services, Food Safety and Inspection Service, U.S. Department of Agriculture, Washington, DC 20250, (202) 447-6042.

SUPPLEMENTARY INFORMATION:

Executive Order 12291

The Administrator has determined that this final rule is not a "major rule" under Executive Order 12291. It will not result in an annual effect on the economy of $100 million or more. There will be no major increase in costs or prices to consumers; to individual industries; to Federal, State, or local government agencies; or to geographic regions. This final rule will not have a significant adverse effect on competition, employment, investment, productivity, or the ability of United States-based enterprises to compete with foreign-based enterprises in domestic or export markets.

This final rule provides for the voluntary use of gamma radiation sources of cobalt-60 and cesium-137 to control *Trichinella spiralis* in pork carcasses or fresh cuts of pork carcasses that have not been cured or heat processed. Current Federal meat inspection regulations do not provide for the use of radiation sources in any type of meat processing operation.

Effect on Small Entities

The Administrator has determined that this action will not have a significant economic impact upon a substantial number of small entities as defined by the Regulatory Flexibility Act (5 U.S.C. 601 *et. seq.*). This final rule will impose no new compliance or reporting requirements on industry. This final rule authorizes the use of gamma radiation sources as a voluntary method to control trichinae in various pork products.

Comments

The issuance of this final rule is consistent with the provisions of § 318.7(a) (2) and (3) of the Federal meat inspection regulations (9 CFR 318.7(a) (2) and (3)). As such, comments have not previously been solicited. However, interested persons may comment to the Department and provide any available information which may raise questions about this action within 60 days following the effective date of this final rule.

Background

Federal regulations require the treatment of many pork products to destroy trichinae (9 CFR 318.10). A trichinosis problem still exists in varying degrees throughout most parts of the world. Since 1950, the number of annual reported cases of trichinosis in the United States has ranged from a high of 400 in 1951 to a low of 45 in 1983. However, these figures are not a reflection of the true number of cases because many sub-clinical or mild clinical cases are not reported or go undiagnosed. Therefore, there remains a need for continuing evaluation of current procedures and consideration of other methods that are effective for the control of trichinae.

Irradiation as a Food Additive

Sources of gamma radiation are classified by law as "food additives" and are regulated as such by the FDA. A source of radiation is specifically defined as a food additive in section 201(s) of the Federal Food, Drug, and Cosmetic Act (FDCA) (21 U.S.C. 321(s)). The Senate report on the Food Additive Amendments of 1958 made it clear that "[s]ources of radiation (including radioactive isotopes, particle accelerators and x-ray machines) intended for use in food processing are included in the term 'food additive' as defined in this legislation" (S. Rep. No. 2422, 85th Cong., 2d Sess. 63 (1958)).

Current FDA regulations (21 CFR Part 179) permit the irradiation of wheat or wheat flour (to control insects), white potatoes (to control sprouting), spices and seasonings (to control insects and/or micro-organisms), and enzyme preparations (to control insects and/or micro-organisms). In July 1985, the FDA amended § 179.22 (21 CFR 179.22) to permit the use of gamma radiation sources for the treatment of pork carcasses or fresh, non-heat-processed cuts of pork carcasses to control *Trichinella spiralis* (50 FR 29658).

Industry Petition

On July 22, 1985, in response to a petition from Radiation Technology, Inc., Rockaway, N.J., the FDA amended its food additive regulations to permit the use of gamma radiation sources for treatment of pork carcasses or fresh, non-heat-processed cuts of pork carcasses to control *Trichinella spiralis* (50 FR 29658). Following the FDA's approval of gamma radiation sources for control of trichinae in pork on July 30, 1985, Radiation Technology, Inc., Rockaway, N.J., requested that FSIS approve irradiation in accordance with FDA regulations.

Food Safety

In its proposal of February 14, 1984, the FDA explained that the Bureau of Foods Irradiated Foods Committee had concluded that food irradiated at doses not exceeding 1 kiloGray (or 100 kilorads)[1] is safe for human consumption (49 FR 5714, 5715). FDA also stated that at dose levels below 100 kilorads the difference between an irradiated food and a comparable nonirradiated food, is so small as to make them indistinguishable with respect to safety. (49 FR 5714, 5716.)

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[1] The System Internationale (SI) unit for expressing the amount of absorbed radiation dose is the Gray (joules/kilogram, abbreviated Gy). The older term is rad. The equivalent value in rads (100 rad = 1 Gy) will be enclosed in parentheses. The prefixes kilo (k) and mega (M) represent a thousandfold and millionfold, respectively. Thus, kilorad means a thousand rads and megarad means a million rads.

Furthermore, FDA evaluation of the petition to permit gamma irradiation of pork considered histopathology data from a U.S. Department of Agriculture irradiation study conducted by Raltech Scientific Services. This study was composed of twenty different studies relating to safety, toxicology and genetic research using fruit flies, dogs and mice. The radiation doses used in these studies were 45 to 60 times higher than the doses authorized by FDA and requested for approval by Radiation Technology Inc., in its petition. The Raltech study started in 1976, and a final report was issued in 1984.

During its evaluation, FDA requested a peer review by the National Toxicology Program's (NTP) Board of Scientific Counselors of the relevant histopathology data on mice fed irradiated chicken. The NTP Board concluded that the available data did not allow the study to be categorized as demonstrating a carcinogenic response. (50 FR 29658).

The FDA regulation of July 22, 1985, permits the use of gamma radiation to treat pork carcasses or fresh, non-heat-processed cuts of pork carcasses. The Agency is issuing this rule for the treatment with gamma radiation of such products that are packaged in any type of containers which have been approved by the Agency for irradiated product. Decisions with respect to the labeling of such products to assure that they are not misbranded under the Federal Meat Inspection Act (21 U.S.C. 601(n)) will be made on a case-by-case basis pursuant to approval of such labeling under the Act (21 U.S.C. 607).

Rationale for Issuing a Final Rule

In the **Federal Register** of July 19, 1983 (48 FR 32749), the Agency published a final rule amending the regulations governing approvals for the use of added substances, including food additives, in preparing FSIS-regulated products. The purpose of those amendments was to provide procedures that would eliminate unnecessary delays and expense when prior review by FDA had served to resolve all legitimate questions (48 FR 32749, 32750). Thus, under § 318.7(a) (2) and (3) of the regulations, approval of the use of a food additive listed in FDA regulations can be granted, and a final rule amending the chart in paragraph (c)(4) issue, if the Administrator has determined that (1) the food additive's use will not render the product in which it is used adulterated, misbranded, or otherwise not in compliance with the requirements of the Federal Meat Inspection Act, and (2) its use is functional and suitable for the product and is permitted for use at the lowest level necessary to accomplish the stated technical effect (9 CFR 318.7(a) (2) and (3) and (c)(4)).

The Administrator finds that the information currently available to the Agency indicates that these criteria have been met. Therefore, the Administrator is issuing this final rule amending the Federal meat inspection regulations to include the use of gamma irradiation within specified minimum and maximum absorbed doses to control *Trichinella spiralis* in pork carcasses, or fresh or previously frozen cuts of pork carcasses that have not been cured or heat-processed.

The Administrator has also determined, as required by § 553(d)(3) of the Administrative Procedure Act (5 U.S.C. 553(d)(3)), that this rule shall be effective upon the date of its publication. This determination is based upon the fact that FDA has previously found ionizing radiation to be safe and suitable for treatment of fresh pork to control *Trichinella spiralis*. In good faith reliance upon FDA's approval of irradiation as a food additive, one or more companies have already made preparations to immediately begin using this technology. The Administrator further determines that additional delay in permitting commercial use of this process would create a hardship on such companies, and would serve no public purpose.

The FDA's regulations on irradiation in the production, processing, and handling of food are contained in 21 CFR Part 179. In the list of Title 21 Parts in § 318.7(a)(2)(i) of the Federal meat inspection regulations (9 CFR 318.7(a)(2)(i)), Part 179 was inadvertently omitted. FSIS intended to include all Parts of FDA regulations that may include provisions bearing on FDA-approved substances for use in products regulated under the FMIA. Consequently, this rule also amends the list of Title 21 Parts cited in § 318.7(a)(2)(i) of the regulations to include Part 179.

List of Subjects in 9 CFR Part 318

Food additives, Food labeling, Meat and poultry products, Preparation of products.

For reasons explained in the preamble, Part 318, Subchapter A, Chapter III of Title 9, Code of Federal Regulations, is amended as set forth below.

PART 318—ENTRY INTO OFFICIAL ESTABLISHMENTS; REINSPECTION AND PREPARATION OF PRODUCTS [AMENDED]

9 CFR Part 318 is amended as follows:

1. The authority citation for Part 318 continues to read as follows:

Authority: 34 Stat. 1260, 81 Stat. 584, as amended (21 U.S.C. 601 *et seq.*); 72 Stat. 862, 92 Stat. 1069, as amended (7 U.S.C. 1901 *et seq.*); 76 Stat. 663 (7 U.S.C. 450 *et seq.*), unless otherwise noted.

2. In § 318.7(a)(2)(i) (9 CFR 318.7(a)(2)(i)) "179," is inserted between "173," and "182", and the paragraph is revised to read as follows:

§ 318.7 Approval of Substances for use in the preparation of products.

(a) * * *

(2) * * *

(i) The substance has been previously approved by the Food and Drug Administration (FDA) for use in meat or meat food products as a food additive, color additive, or as a substance generally recognized as safe and is listed in Title 21 of the Code of Federal Regulations, Parts 73, 74, 81, 172, 173, 179, 182 or 184.

* * * * *

3. In Part 318, the chart in § 318.7(c)(4) is amended by adding a new Class of Substance titled "Sources of Radiation" immediately after "Rendering agents" to read as follows:

§ 318.7 Approval of Substances for use in the preparation of products.

* * * * *

(c) * * *

(4) * * *

Class of substance	Substance	Purpose	Products	Amount
*	*	*	*	*
Sources of radiation	Ionizing radiation limited to gamma rays from cobalt-60 or cesium-137.	To control *Trichinella spiralis*	Pork carcasses, or fresh or previously frozen cuts of pork carcasses that have not been cured or heat-processed.	Minimum absorbed dose of 0.3 kiloGray (30 kilorads) to a maximum absorbed dose of 1 kiloGray (100 kilorads).
*	*	*	*	*

Done at Washington, D.C., on January 9, 1986.

Donald L. Houston,

Administrator, Food Safety and Inspection Service.

[FR Doc. 86-845 Filed 1-14-86; 8:45 am]

BILLING CODE 3410-DM-M

LABELING OF IRRADIATED PORK AND PRODUCTS CONTAINING IRRADIATED PORK

1. Features required for labeling as listed in 9 CFR 318.2 are also required for labeling of irradiated pork and products containing irradiated pork.

2. Labeling for irradiated pork and products containing irradiated pork must bear a statement to this effect (e.g., "Irradiated," "Treated with Radiation," "Contains Irradiated Pork," etc.). The statement shall be placed on the label's principal display panel in letters no less than one-half the size and in the same style of letters used for the product name. An approved logo may be used in addition to a labeling statement, but not without one.

3. Labels for wholesale packages of irradiated pork and products containing irradiated pork must bear the additional statement: "--do not irradiate again." The additional statement must be placed contiguous to and appear in the same size and style of type as the statement in item 2.

4. Labeling statements about the use of irradiation (in items 2 and 3) may be added to approved labels by the application of pressure sensitive stickers. These stickers must be of such a nature that the sticker's removal from the package leaves evidence that the label has been altered.

5. When bulk packages of irradiated pork are sold to retail stores, the retail store must be furnished with package inserts--which the retail store will apply--to indicate that the product has been irradiated. These inserts can not show the inspection legend since they will be applied at other than an official USDA establishment. The only required feature of these inserts is a statement to the effect that the product has been irradiated. Use of a logo is optional.

6. Fresh irradiated pork and non-shelf-stable products (i.e., products which have not been dried or canned) containing irradiated pork must bear an appropriate handling statement, such as, "keep refrigerated," or "keep frozen."

7. A Partial Quality Control program for irradiated product must be approved by the Processed Products Inspection Division before labeling may be used.

8. Some foreign countries which permit the use of irradiation may have officially approved logos or statements to indicate that the product has been irradiated. Labels for irradiated pork and products containing irradiated pork which are destined for export may bear the irradiation logo or statement used by the country to which the product will be shipped. An official notification from the foreign government that the logo or statement is acceptable may be required before approval.

PARTIAL QUALITY CONTROL (PQC) PROGRAM GUIDELINES FOR ESTABLISHMENTS WHICH IRRADIATE FRESH (UNCURED), NON-FROZEN, OR PREVIOUSLY FROZEN AND THAWED BOXED PORK

Each establishment desiring to irradiate fresh (uncured), non-frozen, or previously frozen and thawed boxed pork shall submit a PQC program for review and approval by USDA (address PQC programs to: Processed Products Inspection Division - MPITS, Food Safety and Inspection Service, U.S. Department of Agriculture, Washington, DC 20250).

A PQC program must be developed and approved for each irradiation facility. A draft guideline is available from the above address; however, the program is extensive and subject to considerable change. Following is an outline of the major items to be addressed in the PQC program.

A. **Pre-processing evaluation of incoming product prior to unloading** (e.g., verification of approved packaging; acceptable temperature of product; acceptable condition of product; verification of destination labeling obligations; and, proper label/net weight/package size/bulk weight/pallet configuration specifications).

B. **Pre-processing evaluation of unloaded product prior to processing** (e.g., verification of the quantity of product in the shipment; acceptable temperature of product; acceptable condition of product; proper label/net weight/package size/bulk weight/pallet configuration specifications; and, proper irradiation source activity).

C. **Processing evaluation** (e.g., procedure to establish the absorbed dose for each change in product label/net weight/filled box weight/pallet configuration/bulk density/source activity; types of dosimeters used to establish the absorbed dose and for routine processing; procedure for placement of dosimeters to establish the absorbed dose and during routine processing; procedure for reading the dosimeters and for calibrating all equipment used in measuring the absorbed dose; and, rework procedure for product which receives a partial dose).

D. **Post-processing evaluation** (e.g., procedure to assure that the product has received at least the minimum absorbed dose and no more than the maximum absorbed dose; recall procedure; acceptable temperature of product; and, verification of proper label).

In addition, each irradiation facility must submit documentation which supports its procedures (e.g., commissioning information showing rate of activity over time in various bulk density products; establishment of absorbed dose procedure; dosimeter calibration procedures within house and with a traceable source; equipment calibration procedures; locations of the minimum and maximum absorbed dose positions; tolerances for variations in bulk density within a pallet, between pallets, and overall effect on the absorbed dose; and, computer program control process or manual control process, which must be consistent and accurate).

PARTIAL QUALITY CONTROL (PQC) PROGRAM GUIDELINES FOR ESTABLISHMENTS WHICH PACKAGE AND SHIP PRE-LABELED PORK TO AN OFFICIAL IRRADIATION FACILITY

Each establishment desiring to ship pre-labeled ("irradiated") fresh (uncured), non-frozen, or previously frozen and thawed pork to an official irradiation facility to be irradiated shall submit a PQC program for review and approval by USDA (address PQC programs to: Processed Products Inspection Division - MPITS, Food Safety and Inspection Service, U.S. Department of Agriculture, Washington, DC 20250).

The PQC program shall contain a description, with control procedures, for all aspects of the preparation, packaging, labeling, and shipment of the product to the irradiation facility, as well as procedures to be used for notifying the destination establishment (e.g., other Federal facility or wholesale/retail outlet) of labeling obligations for the irradiated product.

Following is an outline of items to be addressed in the PQC.

A. A letter of application shall be submitted to USDA for approval of the PQC program. Applications must contain the following information:

1. Name of company and establishment number. Name of establishment official who will be responsible for preparing product. Official company signature.

2. Objective of the program.

3. Statement that all data and information generated in support of the PQC program will be maintained for specific time period (e.g., number of years and/or months).

4. Statement that all records which document the PQC program will be made available to USDA personnel.

5. Total number of facility employees. Number of employees that will be used in the Quality Control (QC) program. Responsibilities of the QC employees.

6. Plant profile showing approximate weekly production volume of processed product.

B. The following elements are essential in the preparation, packaging, and shipment of pork product to an irradiation facility for treatment:

The irradiation facility should provide the origin establishment with assistance in developing a protocol which identifies (1) labeling instructions (e.g., shipping containers must be pre-labeled with the irradiation facility's Establishment #, or be labeled with the origin Establishment #, with a "distribution by Establishment X" statement included); (2) the approved label to be on shipping containers and/or retail packages; (3) the type of pork product to be shipped; (4) net weight of product per box; (5) box dimensions; (6) pallet configuration (pallet stacking instructions); and, (7) special shipping instructions (e.g., stretch wrapping or banding each pallet).

C. Control procedures for the above information are as follows:

1. **Raw material**. For each type of pork cut (e.g., bone-in loin chops; boneless, center-cut loins; or bone-in fresh hams), indicate how the pork product is selected for uniformity of condition, size, and weight.

a. Type of pork cut - what items will be included in the PQC program?

b. Weight ranges - for each item, how will the weight be verified and what will the tolerances be for individual weight and shipping container weight variations?

2. **Packaging material verification**. FDA regulations specify what packaging materials are allowed for use during the irradiation of prepackaged foods (21 CFR 179.45). Establish procedure to verify that the packaging materials to be used are approved for such use.

a. Certification - Procedures to verify that the packaging material, as well as other packing and wrapping material which contacts the meat, is approved for use in irradiation. Procedures which verify that each time the packaging material is used it is from the same lot that was identified as being approved for such use.

b. Verification of size and shape of shipping container and/or retail container - procedures which verify that the packaging material is of the proper dimension and is uniform throughout each lot.

3. **Packaged product control**. Procedures which assure that all packages of product are packed consistently within the shipment each time a particular product is shipped (e.g., product is packed in plastic bag inside a wax coated box or unpackaged inside a wax coated box.)

4. **Net weight control**. Procedures which verify scales, tare weight, sampling, monitoring, records, and control checks (including product, package size, production line, codemarks, weight group, scale calibration, sampling times, target weight, required weight, and limits for individual/subgroups).

Verification - net weights will have to be verified on the shipping containers and/or retail packages with procedures to limit variation.

5. **Labeling**. Labeling options to be used (i.e., will product be labeled with the origin Establishment # or with the irradiation facility's number?).

a. Control - procedures which control use of the label within the origin facility so that only product to be shipped to the irradiation facility is labeled as irradiated.

b. Process - procedures which verify that correct labels are applied to each type of product.

6. **Distribution control**. Label inserts must either be placed within bulk-packed shipping containers at the origin facility or a control procedure must be developed which assures that bulk-packed products are labeled correctly after the product is irradiated. In addition, a control procedure must be developed which assures that destination establishments are aware of labeling and disposition requirements for the irradiated product.

7. **Shipping instructions**. Procedure for loading product into the truck (i.e., the product will be stacked on pallets and stretch wrapped).

a. Type of product - procedures which segregate one type of product from another in the same shipment.

b. Packing configuration - procedures which indicate how the product will be stacked on pallets and how many boxes will be on each pallet.

c. Bulk density - procedures which control the packing of pallets so that a particular bulk density (a factor of the total weight of the pallet load divided by the total volume of the pallet load) is uniform throughout the shipment.

d. Proper identification of product - since this product is labeled as if it has already been irradiated, procedures must be developed which verify how the origin Establishment will identify that the product on the truck has not yet been irradiated; that is, what stickers or labels will be included on each pallet load within the shipment to state that the product has not yet been irradiated?

e. Pallet wrapping instructions - procedures which describe the wrapping of each pallet load to prevent boxes on one pallet from falling to the floor or onto another pallet, and to prevent the pallet load configuration from changing. Will pallet loads be stretch wrapped or banded?

8. **Bill of lading**. Since this product will be shipped from the origin Establishment to the irradiation facility under USDA seal, what procedures will document and verify on the bill of lading (1) the name of the pork product, (2) net weight per box, (3) box dimensions, (4) bulk density, (5) certification of packaging material used, (6) certification of destination establishment which acknowledges labeling and disposition requirements, (7) total pallet count, (8) date of shipment, (9) origin Establishment #, (10) destination facility's Establishment #, and (11) USDA seal number?

9. **Refrigeration during shipment**. Procedures which assure that the product is shipped under refrigeration to the irradiation facility.

10. **Product recall**. Procedures for implementing a product recall program.

11. **Example forms**. Origin Establishment must submit examples of the forms, labels, hold tags, etc., intended for use.

UNITED STATES DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
WASHINGTON, D. C.

FSIS NOTICE | 14-86 | 03/05/86

MARKING AND MOVEMENT OF REFUSED ENTRY PRODUCT

Effective March 1, 1986, all imported product that is refused entry will be permanently marked with the official "U.S. Refused Entry" stamp. The 10 Import Field Offices will furnish the required stamps to domestic and import inspectors. This stamp remains under the control of inspection personnel.

Only employee(s) specifically designated by the establishment for the task will be permitted to stamp refused entry product. One stamp will be applied to each shipping container or carcass of refused entry product. The stamp will be applied to the display panel of shipping containers. The inspector must verify that the appropriate amount of product is stamped and must enter this information in the refused entry log.

Inspectors will no longer be required to observe the movement of refused entry product and will no longer need to complete the "Verification of Export" memo (AD-311).

Refused entry product must be stored intact and kept segregated from other product. MP Form 32 (Refused Entry Placard) will **not** be used to identify this product.

Movement And/Or Export Of Refused Entry Product

1. Import Field Office personnel will ascertain when refused entry product is moved and/or exported by reference to documents provided by the importer or broker showing the movement and/or export of refused entry product. In the absence of such documentation, the Import Field Office will refer the case to FSIS' Compliance Program for resolution.

2. Acceptable documentation:
For product moving by truck or train, delivery tickets, dock receipts or other appropriate receipts are acceptable.

For product exported on a vessel, the proof must show that it was actually onboard the vessel and left the country. An onboard bill of lading or the ship's final manifest are acceptable.

DISTRIBUTION: All MPI Offices, T/A Inspectors, Plant Management, T/A Plant Management, Science and Compliance Offices, Import Offices, R&E, ABB TRA	**NOTICE EXPIRES:** 03/05/87	**OPI:** IP, Import Inspection Division

Refused Entry Product Returning To Canada

The inspector obtains FSIS Form 9135-1, Notice of Shipment of Refused Entry Product, available from the Import Field Office, and completes Sections "a", "b" and "c". This form will be sent with a copy of the MP-63, Refused Entry Notification, with the shipment of refused entry product. The Canadian official at the receiving establishment will complete section "d" of FSIS Form 9135-1 and will return the form to the originating Import Field Office.

D Houston

Administrator

UNITED STATES DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
WASHINGTON, D. C.

FSIS NOTICE

15-86 | 3-14-86

BACON PROCESSING PROCEDURES (IN-PLANT CONTROLS)

Section 319.107 of the meat and poultry inspection regulations states that the weight of cured pork bellies ready for slicing and/or labeling as "Bacon" shall not exceed the weight of the fresh uncured pork bellies.

Manufacturers of bacon should utilize processing procedures that will consistently produce product in compliance on a production lot by production lot basis. In order for inspectors to determine compliance with section 319.107, manufacturers of bacon must make their processing procedures available to the assigned inspector(s).

The bacon processing procedures should at least identify the following information:

1. Ingredients of cure (pickle formulation) by percentages;
2. Intended (target) pickle pickup (pump/immersion) percentage;
3. Drain time (up to 30 minutes), if any;
4. Actual pickle pickup (pump/immersion) percentage;
5. Cooking shrink (smokehouse/water bath, etc.) percentage; and
6. Cooler shrink percentage.

Inspectors will:

1. Apply in-plant control checks to monitor productions;
2. Determine if plant operators adhere to their procedures; and
3. Assure that manufacturers meet their responsibilities to prepare product in compliance.

DISTRIBUTION:	**NOTICE EXPIRES:**	**OPI:**
All MPI Offices, T/A Inspectors, Plant Management, T/A Plant Management, Science and Compliance Offices, Import Offices, R&E, TRA, ABB	3-14-87	MPIO/RO

Circuit supervisors will lend assigned inspectors necessary guidance and direction to assure that in-plant control checks are effective and uniformly applied in all plants where bacon is prepared.

The requirements identified in this publication must be effectively in place not later than March 31, 1986, in all plants that produce bacon.

W. L. Horne

Acting
Deputy Administrator
Meat and Poultry Inspection Operations

UNITED STATES DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
WASHINGTON, D. C.

FSIS NOTICE

21-86 | 4-15-86

CONDITIONALLY APPROVED LABELS

Labels may be approved by the Standards and Labeling Division (SLD) with the understanding that certain conditions must be met prior to either the printing of the label or its use. These conditions are stamped somewhere on the application form in red ink by SLD. A few examples of the type of conditions that may be applied are: a partial quality control program is required; the official inspection legend is in the form required by Part 312 of the Meat and Poultry Inspection Regulations; the labeled product is not for retail sale; the product must meet the Meat Grading Branch requirements; and the ingredients listed must be in order of their predominance.

Approved label application forms received from SLD must be carefully examined to identify any conditions stated. The Inspector-in-Charge (IIC) is responsible for the establishments strictly following the conditions stated for use of the label. Conditions applied to approved sketches by SLD must be carried over onto the final label application form when the IIC approves the final label.

Where an approved label application form bears a conditional stamp(s) applied by SLD and there is a question as to its significance, the inspector should consult with his/her supervisor. Further inquires, if necessary, should be directed to the regional office or headquarters staff through normal channels.

Deputy Administrator
Meat and Poultry Inspection Operations

DISTRIBUTION: All MPI Office T/A Plant Inspectors, T/A Plant Management, Science and Compliance Offices, R&E, TRA, ABB, Import Offices
Plant Management

NOTICE EXPIRES: 4-15-87

OPI: MPITS/Standards and Labeling Division

UNITED STATES DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
WASHINGTON, D. C.

FSIS NOTICE

25-86 | 4-24-86

OFFICIAL NUMBERS FOR FEDERAL BRANDS--BUFFALO AND GAME ANIMALS

This notice provides information to FSIS personnel and the regulated industry concerning the official establishment number to be used for establishments handling both red meat and buffalo. This notice also provides information on official numbers that will be assigned for new Federal establishments that will be slaughtering and/or processing only buffalo and for new Federal establishments that will be slaughtering and/or processing only game animals.

For Federal establishments that slaughter and/or process both red meat and buffalo, the official establishment number will be the number assigned to the official red meat establishment. The separate buffalo number will be replaced by the red meat number of the establishment. The number to be used within the Federal triangular brand for marking buffalo and buffalo meat food products will be the same as the number contained within the Federal circular red meat brand.

A new official buffalo inspection establishment that slaughters only buffalo will be given the next available official establishment number instead of a number from the previously reserved 5000 or 15000 series. A new establishment that wishes to slaughter only game animals, other than buffalo, will be assigned a number from the 5000 or 15000 series.

Deputy Administrator
Meat and Poultry Inspection
Operations

DISTRIBUTION: All MPI Offices, T/A Inspectors, Plant Management, T/A Plant Management, Science and Compliance Offices, ABB, TRA R&E	**NOTICE EXPIRES:** 4-24-87	**OPI:** MPIO, Regional Operations

UNITED STATES DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
WASHINGTON, D.C.

CHANGE TRANSMITTAL SHEET

☒ DIRECTIVE
☒ REVISION
☐ AMENDMENT
☐ OTHER

FSIS DIRECTIVE 5730.1, Rev. 1, AUTHORIZATION OF STATE EMPLOYEES TO PERFORM FEDERAL INSPECTION

5730.1
Rev. 1

4-7-86

I. PURPOSE

This document transmits the revision to FSIS Directive 5730.1 and provides instructions to users regarding the removal of FSIS Directive 5730.1.

II. INSTRUCTIONS

The attached directive supersedes FSIS Directive 5730.1. Please discard FSIS Directive 5730.1.

III. CANCELLATION

This change transmittal is cancelled when contents have been filed and FSIS Directive 5730.1 has been discarded.

Deputy Administrator
Meat and Poultry Inspection Operations

Attachment
FSIS Directive 5730.1, Rev. 1

DISTRIBUTION: All MPI Offices, T/A Inspectors, Plant Management, T/A Plant Management, Science and Compliance Offices, ABB, TRA, Import Offices, R&E

OPI: Meat and Poultry Inspection Operations/FSR

UNITED STATES DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
WASHINGTON, D.C.

FSIS DIRECTIVE

5730.1
Rev. 1

4-7-86

AUTHORIZATION OF STATE EMPLOYEES TO PERFORM FEDERAL INSPECTION

I. PURPOSE

This Directive sets forth the FSIS policy and procedures for authorizing State employees to perform inspection duties in Federal plants.

II. CANCELLATION

This Directive cancels FSIS Directive 5730.1, dated 2/6/85.

III. REASON FOR REISSUANCE

To update FSIS procedures for authorization of State employees to perform Federal inspection and to permit State employees to conduct inspection of buffalo (American bison) as well as other game animals in Federal plants.

IV. AUTHORITY

A. Section 301 of the FMIA (21 U.S.C. 661) and Section 5 of the PPIA (21 U.S.C. 454), as amended, and the regulations promulgated thereunder, require that State inspection programs be at least equal to the requirements of these Acts.

B. **The Agricultural Marketing Act** of 1946, as amended, provides the Secretary of Agriculture with the authority to furnish a voluntary inspection service for buffalo (American bison) as well as other game animals (7 U.S.C. 1622).

C. **Talmadge-Aiken Act** of 1962 (7 U.S.C. 450) provides for utilizing State employees to conduct inspection in Federal plants.

D. **Cooperative Agreements** signed by USDA and the State provide for cross utilizing State employees in Federal assignments on a temporary basis and to staff Federal plants with State employees on a permanent or full-time basis.

DISTRIBUTION: All MPI Offices, T/A Inspectors, Plant Management, T/A Plant Management, Science and Compliance Offices, Import Offices, R&E, ABB, TRA

OPI: Meat and Poultry Inspection Operations, FSR

E. **Hatch Political Activities Act** of August 2, 1939, as amended, 5 U.S.C. 118; applies Federal political activity restrictions to State and local employees whose principal employment is with an activity financed in whole or in part by Federal loans or grants.

F. **Federal Personnel Manual** Supplement 990-1, Chapter 15, Section 1502, outlines OPM policy regarding Hatch Act restrictions.

V. FORMS AND ABBREVIATIONS

The following will appear as abbreviated in this directive:

MPIO	Meat and Poultry Inspection Operations
FMIA	Federal Meat Inspection Act
PPIA	Poultry Products Inspection Act
VMO	Veterinary Medical Officer
DVM	Doctor of Veterinary Medicine
OPM	Office of Personnel Management
OIG	Office of the Inspector General
FBI	Federal Bureau of Investigation
MP Form 472	Request for Federal Approval of State Employee Under Cooperative Agreement
Authorization Card	FSIS Form 1000-1
FSIS Form 1234-1	Bribery Reporting Card

FSQS Form 1000-1 and MP Form 472 have been revised to change the Agency name from Food Safety and Quality Service and Animal and Plant Health Inspection Service respectively to Food Safety and Inspection Service. Existing forms may be used until supplies are exhausted.

VI. POLICY

A. FSIS policy is to ensure that products produced under mandatory or voluntary inspection are wholesome, not adulterated and properly marked, labeled, and packaged. This policy requires that the products be produced in a plant and with equipment which is sanitary and properly maintained.

B. FSIS recognizes the advantages; i.e., economy and efficiency, in the utilization of State personnel in performing meat, poultry, and voluntary inspection functions in Federal plants.

C. All State program supervisors, veterinarians, and food inspectors who conduct inspection in accordance with the provisions of the pertinent Cooperative Agreement must hold a current and valid Federal **Authorization Card** for the item, function, or activity inspected, as provided in Section IX of this Directive.

D. State employees issued **Authorization Cards** will be reevaluated at least every 3 years to ensure that they remain proficient in conducting required inspection procedures pursuant to Sections IX and X of this Directive.

VII. [RESERVED]

VIII. RESPONSIBILITIES

A. **Regional Director**, or designee, will be responsible for:

1. Evaluating the work performance of the State employee and issuing **Authorization Cards** to those State employees who meet the standards set forth in Section IX of this Directive.

2. Reevaluating the work performance of State employees that have been issued **Authorization Cards** at least every 3 years to ensure that they continue to be proficient in performing the required inspection procedures and duties pursuant to Sections IX and X of this directive. State employees found to continue to be proficient will retain the **Authorization Card**.

3. Reissuing the **Authorization Card** to State employees found to be proficient.

4. Suspending or revoking the **Authorization Card** of a State employee in accordance with Attachment 4 of this directive.

B. **State officials** will ensure that:

1. The recommended employees have been properly trained and meet all other requirements.

2. The replacement personnel for annual, sick or other absences also have the required **Authorization Card**.

3. The number of personnel authorized to conduct inspection in Federal plants is sufficient to meet the needs of the Program.

4. The proficiency in performing inspection procedures and duties of employees issued **Authorization Cards** is maintained.

IX. REQUIREMENTS FOR ISSUING AUTHORIZATION CARDS

A. The State employee must have received all required training given at a Federal training center or equivalent courses given within the State. This would include on-the-job training in State or Federal plants. They must also be trained in the specific areas to which the employee will be assigned.

B. The State employee must have the same color vision as required by FSIS employees for the performance of meat and poultry inspection work. Any associated expenses in obtaining this certification must be assumed by the State Agency or the State employee.

C. Employee who is employed as a veterinarian must meet the Federal Qualification Standards (Attachment 3).

D. Foreign-educated veterinarians must demonstrate sufficient listening comprehension and skill in oral expression in English to perform the required duties as provided in the Federal Qualification Standards (Attachment 3).

X. PROCEDURES FOR ISSUING AND/OR SUSPENDING OR REVOKING AUTHORIZATION CARDS

A. Issuing Authorization Cards -- Completion and Distribution of MP Form 472.

1. When a State agency requests Federal approval of a State employee to perform inspection activities, the State agency shall complete the obverse side of the MP Form 472, in triplicate, and forward it to the appropriate regional director.

2. The **Regional Director**, or designee, shall:

a. Determine that the State agency has properly completed MP Form 472 and that the applicant meets the requirements contained in Section IX of this Directive. As necessary, return the form to the State agency for appropriate correction, or append appropriate supplementary instructions for the Area Supervisor.

b. Forward triplicate copy to the Area Supervisor for completion of the evaluation of on-the-job observation. Any supplementary instructions will be forwarded with the form.

c. Upon receipt of triplicate copy by regional director from the Area Supervisor, complete all copies of the MP Form 472 indicating approval or disapproval. Reasons for disapproval must be documented.

d. Not normally grant approval for more than the State agency has requested.

e. Return completed duplicate copy of MP Form 472 to the State Agency, accompanied by the **Authorization Card**, if appropriate.

f. Retain original and triplicate copy of MP Form 472.

B. Completing and Issuing **Authorization Cards**

1. The face of the **Authorization Card** shall be completed by the regional director or designee in accordance with the spaces provided thereon, and shall be signed by the regional director or designee as "Authorizing Official."

a. The expiration date must be shown on all cards and shall not exceed 3 years from date of issuance.

b. The State agency responsible for issuing the **Authorization Card** to inspectors shall be advised to require the card holder's signature in the space along the left margin of the face of the **Authorization Card**.

c. The State agency shall advise inspectors to have the **Authorization Card** in their possession while at an establishment.

2. The reverse side of the **Authorization Card** must show:

a. The legal authority as follows: "Pursuant to the Federal-State Cooperative Act (7 U.S.C. 450), the Federal Meat Inspection Act (21 U.S.C. 601 **et seq.**), the Poultry Products Inspection Act (21 U.S.C. 451 **et seq.**), and/or the Agricultural Marketing Act of 1946, **(Name of State Employee)** is authorized to perform inspection as indicated below."

b. Immediately below the legal authority, in capital letters, one of the following terms as applicable: "VETERINARIAN" or "FOOD INSPECTOR."

c. A clear and precise recording of the item, function and/or activity which may be inspected under authority of the **Authorization Card**. The item, function and/or authority recorded here must be consistent with the substance of the approval on the related MP Form 472.

(1) Either or both of the terms "Slaughter" and "Processed Food" must be shown, as appropriate.

(2) Observing the further breakdown of functions, species, and processes shown on MP Form 472, the exact coverage of the **Authorization Card** should be defined as clearly as possible, with limitations expressed in definite terms.

(3) Such terms as "full," "all," "only," "except," and "limited to," may be used as long as they contribute to a clear definition of the authority granted. Rubber stamps may be used, if desired. In most cases a few words, carefully constructed, can be used to record the exact authority conveyed by the **Authorization Card**. Several examples are provided in Attachment 2.

3. The **Regional Office** shall forward the **Authorization Card** with the duplicate copy of MP Form 472 to the State Agency.

4. **Authorization Cards** shall be valid until suspended, cancelled, revoked or expired. The **Authorization Card** must be returned to the immediate Federal supervisor when services are discontinued or authorization is revoked.

5. **Accountability**

a. **Records.** Regional offices shall maintain accountability records to show the current status of all **Authorization Cards** for which they are responsible. The records shall include information as follows:

(1) Number of **Authorization Cards** on hand and unissued.

(2) **Authorization Cards** issued, by number, and names of employees to whom issued.

(3) **Authorization Cards** reported as lost or stolen.

(4) **Authorization Cards** cancelled or destroyed.

(5) Date that **Authorization Card** holder must be reevaluated.

b. **Clearance of Accountability.** Regional Office shall:

(1) Ensure that **Authorization Cards** are returned when:

(a) Card is suspended or revoked by Federal agency action.

(b) State employment is terminated.

(c) Employee's services are no longer required.

(d) An **Authorization Card** is replaced by a new card which adds or deletes specific duties.

(e) Employee is placed in a nonpay status for more than 1 year for leave without pay or furlough.

(f) A temporary licensing period expires.

(2) Destroy returned **Authorization Cards.**

(3) Instruct card holder to report the loss or theft of **Authorization Cards** promptly.

C. Suspension and/or Revocation of **Authorization Card.**

The reverse side of the original of MP Form 472 shall be completed by the regional director or his designee for suspension and/or revocation of an **Authorization Card**. The guidelines for suspension and/or revocation are provided in Attachment 4.

Deputy Administrator
Meat and Poultry Inspection Operations

Attachments

1. MP Form 472, Request For Federal Approval of State Employee Under Cooperative Agreement
2. FSIS Form 1000-1, Authorization Card
3. Federal Qualification Standards
4. Guidelines Relating to Suspension and/or Revocation of Authorization Card

U.S. DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE

REQUEST FOR FEDERAL APPROVAL OF STATE EMPLOYEE UNDER COOPERATIVE AGREEMENT
FEDERAL-STATE COOPERATIVE MEAT AND POULTRY INSPECTION PROGRAM

STATE

STATE AGENCY

NAME OF STATE EMPLOYEE

EMPLOYED AS A: ☐ VETERINARIAN ☐ FOOD INSPECTOR

STATE AGENCY TO COMPLETE THIS SECTION			FEDERAL AGENCY EVALUATION				
APPROVAL REQUESTED	(Check)		APPROVAL RECOMMENDED (Check)				REASON FOR NEGATIVE RECOMMENDATION
A. FEDERAL TRAINING							
B. FEDERAL LICENSE							
Continuing (3 years)							
Temporary Until ________							
1. Slaughter Inspection			YES	NO			
(a) Ante Mortem							
(b) Post Mortem							
Species:							
(1) Cattle							
(2) Sheep							
(3) Swine							
(4) Goats							
(5) Horses							
(6) Mules							
(7) Other Equines							
(8) Poultry							
	Meat	Poultry	Meat		Poultry		
2. Processed Food Inspection	(Check)		YES	NO	YES	NO	
(a) Boning and Cutting							
(b) Curing and Smoking							
(c) Sausage Manufacture							
(d) Canning							
(e) Edible Rendering and Refining							
(f) Fabrication and Portion Control							FEDERAL EVALUATOR

STATE AGENCY CERTIFICATION

1. The State Agency ☐ has determined ☐ has not determined that the employee named above has normal color vision appropriate to the performance of inspection duties.
2. If licensing as a veterinarian is requested, the State Agency ☐ has ☐ has not satisfied itself as to the professional credentials of the above named employee.
3. If approved for licensing, the above named employee will not be assigned to conduct inspections in any plant in which the employee has financial or other interest such as might impair the employee's ability to apply Federal Standards Objectively.
4. Nondiscrimination provisions incorporated in the applicable cooperative agreement have been observed in making this request for this employee.

DIRECTOR OF STATE INSPECTION PROGRAM

DATE

FEDERAL AGENCY ACTION

1. ☐ Approved (*Limitations:*
2. ☐ Disapproved (*Reasons:*

REGIONAL DIRECTOR

DATE

MP FORM 472 (9/84) REPLACES MP FORM 472 (7/75), WHICH IS OBSOLETE

SUSPENSIONS AND/OR REVOCATIONS	STATE	NAME OF STATE EMPLOYEE

First Suspension:

DATE | FEDERAL AGENCY REPRESENTATIVE | DATE | STATE AGENCY REPRESENTATIVE

Second Suspension:

DATE | FEDERAL AGENCY REPRESENTATIVE | DATE | STATE AGENCY REPRESENTATIVE

Third Suspension:

DATE | FEDERAL AGENCY REPRESENTATIVE | DATE | STATE AGENCY REPRESENTATIVE

Revocation:

DATE | FEDERAL AGENCY REPRESENTATIVE | DATE | STATE AGENCY REPRESENTATIVE

MP FORM 472 *(Reverse)*

U.S. DEPARTMENT OF AGRICULTURE **FOOD SAFETY AND INSPECTION SERVICE**		**AUTHORIZATION CARD**
AUTHORIZATION OR LICENSE NO. A-	DATE OF ISSUANCE	EXPIRATION DATE
THIS CERTIFIES THAT		
whose signature appears hereon, is authorized to perform the duties or services indicated on the back of this card, under regulations issued pursuant to applicable law.		
SIGNATURE OF AUTHORIZING OFFICIAL		
TITLE	DIVISION	

SIGNATURE

FSIS FORM 1000-1 (8/84) Replaces FSQS Form 1000-1 (1/79), which may be used until exhausted.

DUTIES ASSIGNED AND LEGAL AUTHORITY:
Pursuant to the Federal-State Cooperative Act (7 U.S.C. 450) and the Federal Meat Inspection Act (21 U.S.C. 601 et seq.) and/or the Poultry Products Inspection Act (21 U.S.C. 451 et seq.), authorized to perform inspection as indicated below:

VETERINARIAN

Slaughter:
- Ante-Mortem
- Post-Mortem

(Full)

This card must be returned to your immediate Federal Supervisor if your services are discontinued or if the authorization is revoked.

DUTIES ASSIGNED AND LEGAL AUTHORITY:
Pursuant to the Federal-State Cooperative Act (7 U.S.C. 450) and the Federal Meat Inspection Act (21 U.S.C. 601 et seq.) and/or the Poultry Products Inspection Act (21 U.S.C. 451 et seq.), authorized to perform inspection as indicated below:

VETERINARIAN

Slaughter:
- Ante-Mortem
- Post-Mortem

(Limited to Poultry)

This card must be returned to your immediate Federal Supervisor if your services are discontinued or if the authorization is revoked.

DUTIES ASSIGNED AND LEGAL AUTHORITY:
Pursuant to the Federal-State Cooperative Act (7 U.S.C. 450) and the Federal Meat Inspection Act (21 U.S.C. 601 et seq.) and/or the Poultry Products Inspection Act (21 U.S.C. 451 et seq.), authorized to perform inspection as indicated below:

FOOD INSPECTOR

Processed Food:
- Boning and Cutting
- Curing and Smoking
- Canning

(Meat and Poultry)

This card must be returned to your immediate Federal Supervisor if your services are discontinued or if the authorization is revoked.

DUTIES ASSIGNED AND LEGAL AUTHORITY:
Pursuant to the Federal-State Cooperative Act (7 U.S.C. 450) and the Federal Meat Inspection Act (21 U.S.C. 601 et seq.) and/or the Poultry Products Inspection Act (21 U.S.C. 451 et seq.), authorized to perform inspection as indicated below:

FOOD INSPECTOR

Slaughter:
- Ante-Mortem
- Post-Mortem

(Limited to Poultry)

Processed Food:
- All Categories

(Limited to Poultry)

This card must be returned to your immediate Federal Supervisor if your services are discontinued or if the authorization is revoked.

DUTIES ASSIGNED AND LEGAL AUTHORITY:

Pursuant to the Federal-State Cooperative Act (7 U.S.C. 450), and the Federal Meat Inspection Act (21 U.S.C. 601 _et seq._) and/or the Poultry Products Inspection Act (21 U.S.C. 451 _et seq._), authorized to perform inspection as indicated below:

VETERINARIAN

Slaughter:
Ante-Mortem
Post-Mortem

(Limited to Cattle, Sheep, Swine, and Poultry)

This card must be returned to your immediate Federal Supervisor if your services are discontinued or if the authorization is revoked.

DUTIES ASSIGNED AND LEGAL AUTHORITY:

Pursuant to the Federal-State Cooperative Act (7 U.S.C. 450) and the Federal Meat Inspection Act (21 U.S.C. 601 _et seq._) and/or the Poultry Products Inspection Act (21 U.S.C. 451 _et seq._), authorized to perform inspection as indicated below:

FOOD INSPECTOR

Slaughter:
Ante-Mortem
Post-Mortem

(Limited to Cattle, Sheep, Swine, and Poultry)

Processed Food:
All Categories Except Sausage Manufacture

(Limited to Meat)

This card must be returned to your immediate Federal Supervisor if your services are discontinued or if the authorization is revoked.

DUTIES ASSIGNED AND LEGAL AUTHORITY:

Pursuant to the Federal-State Cooperative Act (7 U.S.C. 450), the Federal Meat Inspection Act (21 U.S.C. 601 _et seq._), the Poultry Products Inspection Act (21 U.S.C. 451 _et seq._), and/or the Agricultural Marketing Act of 1946 authorized to perform inspection as indicated below:

VETERINARIAN

Slaughter:
Ante-Mortem
Post-Mortem

(limited to Buffalo)

This card must be returned to your immediate Federal Supervisor if your services are discontinued or if the authorization is revoked.

DUTIES ASSIGNED AND LEGAL AUTHORITY:

Pursuant to the Federal-State Cooperative Act (7 U.S.C. 450), the Federal Meat Inspection Act (21 U.S.C. 601 _et seq._), the Poultry Products Inspection Act (21 U.S.C. 451 _et seq._), and/or the Agricultural Marketing Act of 1946 authorized to perform inspection as indicated below:

FOOD INSPECTOR

Slaughter:
Ante-Mortem
Post-Mortem

(limited to Buffalo)

This card must be returned to your immediate Federal Supervisor if your services are discontinued or if the authorization is revoked.

FEDERAL QUALIFICATION STANDARDS

Determination of Professional Status of State-employed Veterinarians

State agency requests for Federal approval for training or licensing of a State employee as a VMO will be handled as follows:

1. State agency qualification requirements must be at least equal to the qualification requirements for FSIS VMO's. If the State agency certifies that it **has** satisfied itself as to the employee's professional credentials, the State determination will be accepted.

2. If the State agency certifies that it **has not** satisfied itself as to the employee's professional credentials, the qualification requirements established by the Office of Personnel Management in conjunction with the American Veterinary Medical Association will be applied by the regional director. (These standards pertain to professional status only and have no necessary relation to the practical on-the-job evaluation which must also be applied.)

GUIDELINES RELATING TO SUSPENSION AND/OR REVOCATION OF AUTHORIZATION CARD UNDER FEDERAL-STATE COOPERATIVE MEAT AND POULTRY INSPECTION PROGRAM

Suspension or revocation of approval: Approval of a State employee under this agreement may be suspended by the Federal agency at any time when the Federal agency finds that such employee is no longer qualified to carry out responsibilities as an approved inspector pursuant to the guidelines set forth herein.

"Approval" is evidenced by issuance of an **Authorization Card** to a State employee. The card authorizes the employee to conduct inspections under the provisions of the cooperative agreement. Suspension and/or withdrawal of approval means suspension and/or withdrawal of the card. A State employee cannot perform under the cooperative agreement while the card is suspended or if it is withdrawn.

The purpose of this attachment is to provide more specific information about the kinds of performance and conduct which will be considered in determining whether approval of a card holder should be suspended or revoked.

The basic consideration is whether or not the card holder is qualified to carry out responsibilities as an approved inspector under the provisions of the cooperative agreement. It may become necessary to negate the original affirmative decision, on either a temporary or permanent basis, as the card holder goes about the work. Qualifications to perform as required can be impaired or destroyed, of course, by failure to carry out the required professional or technical tasks involved in the actual inspection of meat, meat food products, poultry or poultry products, as assigned. A card holder can just as surely impair or destroy the effectiveness ("qualifications") by engaging in conduct which tends to compromise the authority for carrying out all assigned aspects of this sensitive regulatory function.

Individual decisions will be made (as necessary), in the light of individual circumstances, by responsible Federal agency representatives after consultation with appropriate State agency representatives. Federal agency action will deal strictly with whether the approval and **Authorization Card** should be continued, suspended or withdrawn. Suspension or revocation of Federal approval will provide for an opportunity for the card holder to respond to charges, as set forth in paragraph C of this attachment. The suspension or withdrawal of an **Authorization Card** does not change the status of the individual involved as a State employee. Any disciplinary removal or other personnnel action which the State may find appropriate will be for State determination and should be carried out in accordance with any State procedures which may apply.

Action to permanently withdraw approval may be taken in connection with any suspension, depending upon the seriousness of the situation. Some situations such as bribery will be considered serious enough to revoke approval, where as other minor situations may only result in a suspension. Three suspensions will automatically result in **Authorization Card** revocation. As appropriate in individual circumstances, Federal training may be decided upon as the necessary course of action.

Most State employees will perform their assigned work, and conduct themselves in such a manner, as to remain qualified. Only rarely will it become necessary to consider suspension and/or revocation of Federal approval. For protection against the possibility of suspension and/or revocation, it is important that card holders be informed about the types of performance and conduct which may require consideration of such action. The following discussion provides such information, but it is not necessarily all-inclusive. Other examples of disqualifying performance and conduct can be inferred by comparison with those listed. Perhaps the best operating principle for the card holder to consider is this: Continuing Federal approval depends upon the card holder maintaining technical performance at an acceptable level of competence in accordance with prescribed standards and, at the same time, scrupulously avoiding any official or personal conduct which might impair or threaten ability or authority to so perform.

A. PERFORMANCE

1. Card holders are required to accomplish assigned inspection in accordance with the applicable provisions of the Federal Meat Inspection Act (FMIA), the Poultry Products Inspection Act (PPIA), the Meat Inspection Regulations, the Poultry Inspection Regulations, and supplementary instructions issued by the Federal agency.

2. The Federal agency will conduct such in-plant surveys at each establishment granted inspection under the cooperative agreement (and perform such other functions) as are necessary to assure that the facilities and operations and conduct of inspections at such establishments are in compliance with the applicable provisions of sources cited in the preceding paragraph.

3. Material deficiences, failures or omissions in professional or technical performance required will be cause for consideration of **Authorization Card** suspension and/or revocation.

B. CONDUCT

1. **Bribery**. Soliciting or accepting a bribe by a card holder in connection with the official duties is a criminal offense punishable by fine and imprisonment. A card holder who has been offered a bribe, or who knows of a case in which it is alleged or suspected that a bribe has been offered another card holder, or to a FSIS employee, shall immediately report the incident to the Office of the Inspector General (OIG). FSIS Form 1234-1,

Bribery Reporting Card (11/81), contains an emergency contact number that employees should use in reporting bribes. Cards may be requested through normal supervisory channels. Employees shall not disclose information about the incident without prior approval of OIG or the Federal Bureau of Investigation (FBI).

2. **Relationships with Commerical Firms.**

a. Acceptance by any card holder of any money, gift, or other things of value from the operator of any establishment granted inspection under the Federal-State Cooperative Agreement, or from any other establishment engaged in slaughtering livestock or poultry, or preparing meat, meat food products, poultry or poultry products, or from any employee or agent of any such establishment is prohibited and may be grounds for suspension or revocation of **Authorization Card** approval. The term "other things of value" is meant to include:

(1) **Gifts, Gratuities, Entertainment, and Favors.**

(a) Acceptance of items, no matter how innocently offered or accepted, from "interested parties" may be a source of embarrassment to the State and Federal agencies and the employee involved; may effect the objective and impartial judgement of the employee; and may impair public confidence in the integrity of the employee and the service.

(b) An "interested party" is any person, firm, corporation, other entity, or individual acting on behalf thereof which conducts operations or activities that are regulated by the Agency or has interests that may be substantially affected by the performance or nonperformance of the official duty of the involved employee.

(c) Allowance is made for the occasional exchange of customary social courtesies that are free of any embarrassing or improper implications and are of trivial value (e.g., soft drink or cup of coffee) when the circumstances make it clear that the business of the interested party is not the motivating factor. However, the acceptance of all other gifts, gratuities, entertainment, or other things of value (including complimentary meals and beverages, tangible items, tickets, and passes) from interested parties is strictly prohibited and may be grounds for suspension and/or revocation of card approval.

(2) **Loans.**

(3) **Services**, such as repair of personal automobile, use of establishment property or equipment for personal unofficial use of the card holder, etc.

(a). A card holder is not to perform inspection in or directly affecting any establishment which he/she has a financial interest.

(b). A card holder is not to perform inspection of any animal or poultry product or by-product in which he/she has a financial or proprietary interest.

b. Purchase of Product. Employees may not purchase products, personally or through another individual, from a plant or establishment regulated, inspected, or otherwise controlled by FSIS or by agents authorized as card holders under the authority of this Directive, if the employee performs a function related to the commodity or commodities dealt with or processed in any manner by the plant or establishment, without prior approval from the appropriate FSIS Regional Director or his designee.

3. **Absense Without Permission.**

a. Excessive tardiness without adequate justification will be reason for suspension of the **Authorization Card.**

b. A State employee's **Authorization Card** will be revoked if he/she is absent from assigned duty without permission for more than 15 work-days and (1) fails to be reached by or reply to communications, or (2) without adequate reason fails or refuses to return to duty after the State agency has communicated with him/her.

4. **Personal Conduct.**

a. A card holder found guilty of criminal, infamous, immoral, or notoriously disgraceful conduct which reflects upon the Federal agency is subject to revocation of **Authorization Card.**

b. If a card holder uses intoxicants while on official duty, or if the use of intoxicants causes interference with the performance of official duties, the **Authorization Card** may be suspended and/or revoked.

5. **Falsification, Misuse, or Destruction of Official Reports or Property.**

a. No card holder shall falsify any record or document relating to work under the cooperative agreement, nor conceal material facts by omissions from such records.

b. No card holder may remove, destroy, steal or obliterate any public record.

c. Any claim initiated by a card holder for reimbursement of money spent in travel, or for other purposes reimbursable under the terms of the cooperative agreement, shall be made with absolute accuracy and truthfulness.

d. A card holder may not appropriate any article of Federal property for his/her own use.

e. Except in emergencies threatening loss of life or property, no card holder shall use or permit the use of Federal property for any purpose other than performance of official work.

f. Use of federally-owned passenger-carrying motor vehicles is expressly prohibited, except as may be specifically authorized by a responsible Federal official.

6. **Outside Work**. The matter of whether or not outside work is to be allowed is for resolution between the card holder and the State agency which employs him/her. The interest and concern of the cooperating Federal agency has to do with assuring that any such outside work:

a. Does not interfere with the card holder's performance. This includes work which:

(1) Causes absence without proper authorization during duty hours, or

(2) Prevents him/her from performing effectively or at full capacity while on duty.

b. Does not in any way imply the Federal agency's official or unofficial sanction, support or participation in a private undertaking.

c. Does not entail or tend to give rise to criticism or bring about embarrassment to the Federal agency or the Federal service. For example, such a result could occur when the outside work is:

(1) Related closely to official duties. Such close relationship may tend to give an unfair competitive advantage over other persons engaged in private enterprise.

(2) Involved with a criminal, infamous, dishonest, immoral, or notoriously disgraceful activity.

d. Is in full compliance with State or other governmental laws and regulations. This applies to outside work which requires an official authorization or card. It includes the practice of law, veterinary medicine, pharmacy, real estate, etc.

e. Does not result in any conflict of interest or tend to bias official judgment. This applies whether the work is performed with or without compensation. Such work must avoid even the appearance of a conflict between official duties and outside interests. A conflict of interest can be presumed to arise if the work involves:

(1) Using official information to the detriment of the public service.

(2) Writing, discussing or otherwise commenting upon policies or official programs of the Federal agency except as authorized by specific regulations.

(3) Participating in the commericial activity of an organization which may use the person's name in advertising or otherwise commercialize on his/her official work as a card holder of the Federal agency.

7. **Restrictions on Political Activity**. Provisions of the Hatch Act (Hatch Political Activities Act of August 2, 1939, as amended; 5 U.S.C. 118 i) apply Federal political activity restrictions to those officers and employees of a State or local agency of a State (including a County) whose principal employment is in connection with an activity financed in whole or in part by Federal loans and grants. These restrictions are also enforceable by the United States Office of Personel Management (OPM). **Federal Personnel Manual Supplementary 990-1**, Chapter 15, Section 1502, outlines these restrictions as follows:

a. A State or local officer or employee may not:

(1) Use his/her official authority or influence for the purpose of affecting the result of an election or a nomination for office.

(2) Directly or indirectly coerce, attempt to coerce, command, or advise a State or local officer or employee to pay, lend, or contribute anything of value to a party, committee, organization, agency, or person for political purposes.

(3) Be a candidate for elected office.

b. A State or local officer or employee retains the right to vote as he/she chooses and to express his/her opinions on political subjects and candidates.

C. PROCEDURES FOR SUSPENSION OR REVOCATION

1. Whenever the regional director, or designee, determines that a State employee's **Authorization Card** must be suspended or revoked, the State

employee will be notified in writing. All reasons for the action and the procedures for appeal will be clearly stated.

2. Whenever the regional director, or designee, determines that a State employee's **Authorization Card** must be suspended or revoked, the employee has the right to request a review and modification of the determiniation by the Assistant Deputy Administrator for Meat and Poultry Inspection Operations. This request must:

a. Be in writing and forwarded, through the appropriate MPIO regional director, to the Assistant Deputy Administrator, MPIO, within 14 days of the State employee's notification of the determination.

b. Set forth all the facts and circumstances in support of the request for review and any alternative solutions the State employee thinks appropriate.

3. The decision of the Assistant Deputy Administrator, MPIO, or designee, is a final decision with no further appeal rights.

4. Until a final decision is made, the State employee will not be authorized to inspect under any FSIS cooperative agreement with the State.

UNITED STATES DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
WASHINGTON, D.C.

FSIS DIRECTIVE

6810.1
REVISION 1

4-15-86

GRADEMARK LABELING ON MEAT AND POULTRY PRODUCTS

I. PURPOSE

This directive provides procedures for use by inspectors to ensure accuracy of grade labeling on meat and poultry products.

II. CANCELLATIONS

This directive cancels section 16.8 of the Meat and Poultry Inspection Manual, and MPI Bulletin 82-62 dated 12-7-82.

III. (RESERVED)

IV. REFERENCES

Meat and Poultry Inspection Regulations, Section 381.129; Subchapter C - Regulations and Standards under the Agricultural Marketing Act of 1946, 7 CFR Parts 54 and 70.

V. FORMS AND ABBREVIATIONS

The following will appear as abbreviated in this directive:

MGC	Meat Grading and Certification Branch
MPIO	Meat and Poultry Inspection Operations
PGB	Poultry Grading Branch

VI. PROCEDURES

A. Labeling Meat Quality and Yield Grade.

1. Certified Product. Labels or container markings which refer to Federal specifications (by number and/or words) shall only be approved for use with the understanding that the appropriate meat products are certified by MGC as meeting the required specification. For example, "Ground Beef - PP-B-2120," "Schedule SL--Sliced Bacon," and "IMPS Item No. 114 - Beef Shoulder Clod" are acceptable labels or container markings only if such

---

DISTRIBUTION: All MPI Offices;T/A Inspectors; Plant Management; T/A Plant Management; Science and Compliance Offices; TRA; ABB; R&E; Import Offices

OPI: Meat and Poultry Inspection Operations products are certified by MGC. However, product identified as "Ground Beef," "Sliced Bacon," or "Item No. 114, Beef Shoulder Clod" will not require certification by the MGC.

2. Official USDA Grademarks.

a. Quality. The following USDA quality grademarks may be applied to carcasses by MGC personnel:

(1) Beef--Prime, Choice, Good, Standard, Commercial, Utility, Cutter, Canner.

(2) Veal/Calves--Prime, Choice, Good, Utility.

(3) Sheep-Prime, Choice, Good, Utility, Cull.

(4) Pork--U.S. 1, U.S. 2, U.S. 3, U.S. 4, U.S. Utility

b. Yield. The following USDA yield grademarks may be applied to carcasses by MGC personnel: Beef/Lamb--1, 2, 3, 4, 5.

c. Official USDA Grademarks on Carcasses and Cuts

(1) When steer, heifer, cow, or bullock beef are officially graded, both quality and yield grade designations must remain on grade-identified carcasses, sides, quarters, and wholesale cuts (round, sirloin, shortloin, rib, square-cut chuck, shank, plate, brisket, flanks, or combinations of these cuts) on which the external fat is greater than 3/4 inch thick, unless both such designations are removed. However, the yield grade designations may be removed from carcasses, sides, quarters, and wholesale cuts on which the external fat thickness (natural or trimmed) does not exceed 3/4 inch. In addition, yield grade designations may be removed from subprimal and retail cuts without trimming of external fat. In no case can the yield grade alone be shown on grade labeling.

(2) The Official U.S. Standards for Grades of Carcass Beef specifically prohibits the unnecessary trimming or alteration of external fat on beef carcasses to be presented for grade determination. Inspection personnel observing such actions shall report the matter to his/her supervisor and the local meat grading personnel.

(3) When wholesale or retail cuts from officially graded carcasses are to be labeled or identified with official grade names, such cuts must bear the official USDA grademark--Prime, Choice, Good, etc.--as applied by a USDA grader. Containers of USDA graded beef cuts may be labeled in the following manner, provided control procedures outlined in this Directive are followed.

(a) If containers of cuts of mixed quality and yield grades are grade labeled, they may be labeled with the lowest quality grade included in the container and the words "or higher" (e.g., USDA, Choice or Higher). This may include all Choice or all Prime or any mixture of the two grades.

(b) Yield grade labeling must include all yield grades of beef in the containers (e.g., Yield Grade 1, 2, 3). However, the containers do not have to be labeled for yield grade if the fat thickness of the cuts does not exceed 3/4 inch or, the cuts are subdivisions of wholesale or primal cuts; i.e., boneless wholesale cuts or subprimal or retail cuts. Other grade labeling terminology which is more specific than the above guidelines (e.g., USDA Good or Choice Yield Grade 2 or 3) is permitted.

(c) Abbreviations for the quality grademarks are not acceptable as labeling for USDA grades. Markings as Ch, Cho, or C, etc., shall not be permitted.

(d) USDA grade designations may be preceded by the name of the firm provided the product is prepared from USDA graded meat. For example, labeling meat or containers "Troyer's Choice" is permissible provided it is USDA graded Choice meat.

(4) Quality grade or yield grade identification labeling shall be printed on the containers or on pressure sensitive labels which shall be applied to containers and shall not be handwritten. These labels shall bear the USDA grade designation and the inspection legend if the legend is not printed on or applied to the container.

(5) Upon observing violations such as removal of yield grade stamps or improper container labels, the inspector should retain the carcasses, cuts or containers in question until each cut or carcass has been substantially trimmed per this Directive, or all USDA quality and/or yield grademarks have been removed, or such incidents are reported to his/her supervisor and the local meat grading personnel.

(6) If official USDA grademarks are removed during cutting or trimming, one of the following procedures must be implemented.

(a) All cutting, trimming, packaging, and labeling must be done under continuous USDA grader's supervision.

(b) At plant's request, cuts may be rebranded according to procedures acceptable to MGC.

(c) Any other procedure developed by the plant which ensures control over grademark and labeling of products may be submitted. This procedure shall be submitted through the inspector-in-charge to the MPIO regional office for final approval. These approved procedures will be monitored by MPIO inspectors. A copy of the MPIO approval letter should be sent to the appropriate MGC regional director, Agricultural Marketing Service, listed below.

Eastern Region: Regional Director
USDA, AMS, LS
Meat Grading and Certification Branch
4101 South Halsted Street
Room 217
Chicago, Illinois 60609-2695

Area of responsibility: The States of Maine, Vermont, New Hampshire, Massachusetts, Connecticut, Rhode Island, New York, Pennsylvania, New Jersey, Delaware, Maryland, Ohio, Virginia, West Virginia, Kentucky, Michigan, Indiana, Illinois, Wisconsin, Minnesota, Iowa, and Missouri.

Southern Region: Regional Director
USDA, AMS, LS
Meat Grading and Certification Branch
Earl Cabell Federal Building
1100 Commerce Street
Room 7C59
Dallas, Texas 75242

Area of responsibility: The States of North Carolina, South Carolina, Georgia, Florida, Alabama, Mississippi, Tennessee, Arkansas, Louisiana, Texas, Oklahoma, Kansas, and New Mexico.

Western Region: Regional Director
USDA, AMS, LS
Meat Grading and Certification Branch
206 Livestock Exchange Building
Denver, Colorado 80216-2139

Area of responsibility: The States of Nebraska, North Dakota, South Dakota, Montana, Wyoming, Colorado, Utah, Idaho, Nevada, Arizona, Washington, Oregon, California, Hawaii, and Alaska.

(7) If under an approved grade labeling program an official grademark does not comply with the labeling requirements or is otherwise misused, the MPIO inspector shall:

(a) Retain all product packaged and labeled with such grade name and produced during the shift in which the deviation is discovered until the grade name is removed or obliterated.

(b) Through inspector-in-charge, inform MPIO area supervisor and, if plant has Federal grading service, MGC Branch regional director.

(c) Discontinue product labeling until plant management provides both the MGC Branch area supervisor and the MPIO area supervisor with a written explanation of the incident and action taken to preclude a recurrence. Upon the concurrence of the MGC Branch regional director and the approval of the MPIO area supervisor, product labeling may be reinstated.

(d) If requirements are not met, the inspector-in-charge, in cooperation with plant management, shall initiate action to rescind approved labels or other plant-owned marking devices bearing official grade names.

B. Poultry Grade Labeling.

1. Section 381.129 (b) (1) of the poultry products inspection regulations reserves the letter grade designations A, B, and C for products officially graded by Federal-State grading service. Accordingly, product bearing these marks must be certified by the PGB as meeting applicable requirements. Products labeled with terms such as Prime, Premium, Best, Number 1, or any other indication of superior or top quality must be equivalent to the U.S. Grade A, or under section 381.129 (b) they are considered to have misleading labeling, unless the terms are preceded by possessive nouns or pronouns such as "John Doe's Premium Quality," "Our Best Quality", etc.

2. Inspectors shall spot check to assure that product bearing letter grade designations have been graded by PGB representatives.

3. In plants with both inspection and grading services, such checks are to be done by the grader-in-charge, or by the grader-in-charge and the inspector-in-charge jointly. When spot checks are done by the grader-in-charge, the grading information will be given to inspectors-in-charge for product disposition when applicable.

Deputy Administrator
Meat and Poultry Inspection Operations

UNITED STATES DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
WASHINGTON, D.C.

CHANGE TRANSMITTAL SHEET

☒ DIRECTIVE
☐ REVISION
☒ AMENDMENT
☐ OTHER

FSIS DIRECTIVE Marking Carcasses and Products (Meat)	6810.2 Amend. 1	3-13-86

I. PURPOSE

This document transmits Amendment 1 to FSIS Directive 6810.2, Marking Carcasses and Products (Meat)

II. PRINCIPAL CHANGES

Section V, A, 2 is amended to remove the word "Inspector" from the first sentence.

III. FILING INSTRUCTIONS

Remove Pages	Insert Pages
1 and 2	1 and 2

Deputy Administrator
Meat and Poultry Inspection Operations

Attachment
FSIS Directive 6810.2, Amendment 1

DISTRIBUTION: All MPI Offices, T/A Inspectors, Plant Management, T/A Plant Management, Science and Compliance Offices, R&E, Import Offices, TRA, ABB

OPI: MPITS/Standards and Labeling Division

UNITED STATES DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
WASHINGTON, D.C.

FSIS DIRECTIVE

6810.2
Amend 1

3-13-86

MARKING CARCASSES AND PRODUCTS (MEAT)

I. PURPOSE

This Directive provides procedures for branding carcasses, parts of carcasses, and products.

II. CANCELLATION

This Directive supersedes sections 16.6, 16.7, and 16.11 of the Meat and Poultry Inspection Manual.

III. [RESERVED]

IV. REFERENCES

Sections 311.22, 311.23, 312.2, and 312.3, and Part 316 of the Federal Meat Inspection Regulations

V. PROCEDURES

A. Carcass Marking.

1. Each half carcass shall be legibly marked "U.S. Inspected and Passed" after inspection is completed.

2. Apply brand imprints on carcasses as required to assure the brand will be visible. Inspectors have discretion as to location and number of brand imprints applied to carcasses. However, a minimum of one brand imprint is required on each half carcass.

3. Shrouded carcasses.

a. Shrouding carcasses should not cause brands to become smeared or illegible.

b. If shrouded carcasses are shipped from an official plant, additional brands shall be applied to carcasses if necessary to ensure they are clearly visible without shroud removal.

DISTRIBUTION: All MPI Offices, T/A Inspectors, Plant Management, T/A Plant Management, Science and Compliance, R&E, Import Offices, TRA, ABB

OPI: MPITS/Standards and Labeling Division

4. Carcasses placed in bags or other coverings shall bear prominent and legible official inspection legends on the outer covering. (See section 316.13 of regulations for exceptions.)

5. Cysticercosis beef carcasses passed subject to retention under refrigeration, in accordance with section 311.23 of the meat inspection regulations, may be marked "U.S. Inspected and Passed" just before being placed into a freezing compartment under government lock or seal.

6. Papain injected carcasses shall be marked "Tendered with Papain" by continuous roller brand applied over the round, loin, rib, neck, chuck, foreshank, flank, plate, brisket.

7. "Hide-on" calf carcasses must be marked "U.S. Inspected and Passed" at the originating establishment. Carcasses shipped to other plants must be marked with the receiving establishment number and inspection legend after hide removal.

B. Product Marking.

1. Meat Cuts from carcasses marked at another establishment shall be branded with the official inspection legend and establishment number where cut.

2. "Tender" or words of similar meaning may be branded on pork products heated to at least 140° F. internal temperature.

3. "Ready-to-Eat", "Cooked", "Fully Cooked", "Thoroughly Cooked", or "Ready-to-Serve".

a. These are terms that may be marked on heated and smoked products provided the product shows cooked characteristics such as:

(1) Partial meat separation from bone,

(2) Easy tissue separation, and

(3) Cooked color, texture, and flavor.

This usually requires a minimum internal temperature of 148° F.

b. When marking devices are submitted for approval of these terms, the application should contain complete processing procedures and internal temperatures attained.

4. "Cereal Added", "Nonfat Dry Milk Added", Artificially Colored" and similar qualifying statements shall be marked on product or on marking devices attached to product in the order that the ingredients are added during processing.

UNITED STATES DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
WASHINGTON, D.C.

FSIS DIRECTIVE

7110.2 | 4-16-86

PROTEIN FAT FREE (PFF) GUIDELINES

I. PURPOSE

The purpose of this directive is threefold, as follows:

1. To incorporate eight FSIS Notices into a single permanent issuance.
2. To provide information regarding the PFF Toll Free Telephone Line.
3. To transmit an updated Questions and Answers Guide to the PFF Regulation.

II. CANCELLATIONS

FSIS Notice 21-84, dated 4/24/84.
FSIS Notice 29-84, dated 6/6/84.
FSIS Notice 68-84, dated 10/16/84.
FSIS Notice 69-84, dated 10/16/84.
FSIS Notice 77-84, dated 12/16/84.
FSIS Notice 2-85, dated 1/14/85.
FSIS Notice 24-85, dated 3/27/85.
FSIS Notice 63-85, dated 8/29/85.

III. RESERVED

IV. REFERENCE

MPI Regulation Sections 318.19, 319.104, and 319.105

V. USE OF PFF TOLL FREE TELEPHONE LINE

The PFF toll free telephone line is established to provide State Directors and FSIS Inspectors in Charge (IIC), except those in the Washington Metropolitan area, a direct communication link with the Washington Staff responsible for maintaining the PFF computer data base. This line is limited to those State Directors and IIC's with plants preparing cured pork products under the PFF regulation.

DISTRIBUTION: All MPI Offices, T/A Inspectors, Plant Management, T/A Plant Management, Science and Compliance Offices, Import Offices, R&E, TRA, ABB

OPI: MPITS/Processed Products Inspection Division

The Toll Free number is 800-327-9522. For IIC's in the Washington, D.C., area, the number is 202-447-7077. A log of all calls and the actions taken will be maintained.

The telephone line is to be used when an Absolute Minimum violation is found based on the IIC's or State Director's calculation of the PFF value. The PFF telephone line is used to verify calculations and the recommended action to be taken. **Operational questions are to be referred to MPIO, Regional Operations.**

Prior to using the telephone line, the IIC or State Director must have available the following information:

Establishment Number
Inspector Name
Meat Protein Analysis from Submitted Sample
Fat Analysis from the Submitted Sample
Sample Number from the Sample Request Form
PFF Value (Calculated by IIC)
Product Name on Label
Group from the Sample Request Form
Sampling Phase (Periodic, Daily, Retention)

The data provided will be entered into the computer for calculating the PFF Value, Group Value, Product Value or, in the case of retention, the average PFF sample value. Instructions will be given on the action to be taken; e.g., retain product, release product, change sampling phase, or identify products to be sampled.

VI. TRANSMISSION OF QUESTIONS AND GUIDE

Two video tapes are available from the Area Offices. The "Guide for PFF Analysis Sampling Program" dated July 1985 is available from the Regional Office and should be in all plants producing cured pork products under PFF.

The attached question and answer guide was prepared in order to provide uniform interpretation and application of the regulations.

Deputy Administrator
Meat and Poultry Inspection Operations

ATTACHMENT
Questions and Answers Guide - Cured Pork Products

ATTACHMENT
FSIS DIRECTIVE 7110.2

CURED PORK PRODUCTS QUESTIONS AND ANSWERS

MPITS, PPID
FSIS

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I. LABELING AND STANDARDS

1. **Question**: When are label applications stamped "Requires a QC Program?"

Answer: All labels for cured pork products labeled "(X)% of weight is added ingredients" will be stamped with the QC stamp. The exception to this is when the transmittal form has a statement on it such as "THIS LABEL IS TO BE USED FOR RELABELING RETAINED PRODUCT ONLY."

2. **Question**: When are qualifying statements required?

Answer: Qualifying statements are needed on all products requiring terms such as "with natural juices", "water added" and "(X)% of weight is added ingredients."

3. **Question**: What portion of the labeled product name is considered the qualifying statement for marking purposes?

Answer: That portion of the name which is in addition to the common and usual name.

Example:

Common or Usual Name	**Qualifying Statement**
Ham with Natural Juices	With Natural Juices
Ham Water Added	Water Added
Ham and Water Product 20% of Weight is Added Ingredients	20% of Weight is Added Ingredients

4. **Question**: Are plants able to "label out of trouble"?

Answer: Yes, on a lot by lot basis during the retention phase.

5. **Question**: Is it possible to relabel retained products rather than returning them to the official establishment?

Answer: Yes.

6. **Question**: Is the relabeling of canned ham permitted?

Answer: Yes.

7. **Question**: How should canned, lithograph labeled product be relabeled?

Answer: The method of relabeling should be proposed by the processor for FSIS approval. For example, the product may be repackaged in consumer size containers and relabeled accurately. On consumer size cans FSIS permits pressure sensitive stickers, if the adhesive is a type that will not permit the sticker to be removed.

8. **Question**: If a processor is manufacturing a water added product and the product fails to meet the standard for water added and can be relabeled as a _______ and water product-X% of weight is added ingredients, how can the X% to be shown on the label be determined?

Answer: There are several methods which can be used to determine the amount of added ingredients to be declared on the label of X% product and any of them which may be adequate. Two of these methods are: (1) yield determinations based on plant records such as comparisons between the green weight and the finished weight of the product; (2) use of the USDA chart (see Attachment A).

9. **Question**: Since the PFF regulation requires a quality control program for the production of an X% product, is a processor who gets into trouble with water added product (product which does not meet the water added standard) allowed to relabel the product as X% product without having a quality control program?

Answer: Yes. However, if such production becomes the rule rather than the exception, the processor will be prohibited from producing more X% product until a quality control program is approved for use.

10. **Question**: Can Ham and Water Product be 50% ham and 50% other ingredients?

Answer: No. A ham and water product must be more than 50% ham.

11. **Question**: Can labels for "ham and water product-X% of weight is added ingredients" be approved with a blank space where the percentage normally appears?

Answer: Yes, but only for relabeling purposes. The transmittal form must state that the label is only intended for use in relabeling and then only by the IIC who will determine the figure to be stamped in the space provided. The labels will not be stamped "Require a QC Program".

12. **Question**: Can retained product be down-labeled using pressure sensitive stickers?

Answer: Yes, provided the adhesive is a type which will not permit the sticker to be removed and provided the sticker meets the applicable size/color requirements.

13. **Question**: Are the PFF values the same for all products?

Answer: All products which are labeled with the same common and usual name (including the qualifying statement) must comply with the same standard. For example, a canned ham--water added, and a smoked ham--water added, must comply with the same PFF standard.

14. **Question**: What is the meaning of the term "cooked" which is used in the regulation?

Answer: The term "cooked" is used in the PFF regulation to refer to all processes where heat is applied to the product. For example, products labeled smoked, cooked, or fully cooked will be in the cooked category.

15. **Question**: If a product is heat treated for the destruction of live trichinae, why is it considered cooked by this regulation?

Answer: When a product is heated, the heating process will have a concentrating effect on the protein. Therefore, products that are heat treated are considered cooked for the purpose of this regulation and must meet the appropriate PFF standards.

16. **Question**: Is there any allowance made for the differences in protein content of fresh and PSE pork or frozen pork?

Answer: No.

17. **Question**: What is the PFF value for "Cured Pork"?

Answer: "Cured Pork", uncooked or heat treated, made from any combination of hams, loins, shoulders, butts, or picnics, in whole or in part, which is labeled; e.g., as a part of the product name, in the ingredients statement, qualifying statement, starburst, etc., to indicate the presence of any of the above parts is subject to the **PFF value for pork shoulder**. These products may be sectioned, chunked, diced, or ground.

"Cured Pork" which is not labeled to indicate the presence of hams, loins, shoulders, butts, or picnics or "Cured Pork" made from pork parts not covered by the PFF regulations; e.g., bellies, jowls, hocks, ears, fat-back, tails, etc., **is not** subject to the PFF regulations. If these products are subjected to heat treatment, the products must come back to the fresh uncured weight unless the product name specifically indicates the presence and percentage of the added substances above the fresh uncured weight. (See Policy Memo 084 issued by the Standards and Labeling Division.) If not subjected to heat treatment, the products may contain up to 10 percent added substance without label declaration. If more than 10 percent added substance is added, the presence and amount of the added substance must be declared as a part of the product name. Examples of acceptable names are "Cured Pork and X% Water" and "Cured Pork and Water Product-X% of Weight is Added Ingredients". Whenever a percent is included in the product name, a partial quality control (PQC) program is required. The above applies to "dry salt cured" product also.

18. **Question**: What is the PFF value for raw "cured pork trimmings"?

Answer: The PFF concept is not applicable to trimmings. The product may contain up to 10 percent added substance without label declaration. If more than 10 percent added substance is present, the presence and amount of the added substance must be declared as a part of the product name. Examples of acceptable names are: "Cured Pork Trimmings and X% Water" and "Cured Pork Trimmings and Water Product-X% of the Weight is Added Ingredients". Whenever a percent is indicated in the product name, a PQC program is required.

19. **Question**: How should a mixture of trimmings from various uncooked cured pork products be labeled?

Answer: A processor wishing to combine the trimmings from uncooked cured pork product, such as hams which were injected with various levels of curing solutions, must label these trimmings indicating the highest level of substances added over 10 percent, e.g., "Uncooked Cured Ham Trimmings Injected With Up to 25 percent of a Solution of Water, etc." A PQC program is not required.

20. **Question**: Does the name of the cured pork product affect whether the product is subject to the PFF regulations?

Answer: Yes. If a fanciful name such as Deli Roll is used in lieu of the common and usual name, the product is not subject to the PFF regulations and there is no restriction on the added substance. However, descriptive labeling and a demonstration that the product is not nutritionally inferior to the traditional product may be necessary for some products.

21. **Question**: Can unlabeled or unmarked PFF controlled cured pork products be shipped in fully labeled immediate containers?

Answer: No. Each unit of PFF controlled cured pork product must at least bear the inspection legend, the curing statement, and the appropriate qualifying statement (if applicable).

II. SAMPLING

1. **Question**: Does an entire ham need to be taken as a sample?

Answer: One complete consumer ready unit is necessary for sampling. If that is an entire ham, an entire ham will be used as the sample. Alternative sample preparation may be used at the processors request, provided the equipment necessary for preparing the sample is available at the plant, that is, selecting a consumer ready unit, comminuting the unit, mixing the comminuted sample and selecting a one pound unit of the comminuted sample, under the inspector's supervision.

2. **Question**: Can a center slice be used as the sample unit?

Answer: Yes, but only when a center slice is being sold as the consumer unit. Since the minimum sample size submitted to the laboratory is one pound, more than one center slice may be needed.

3. **Question**: When the sample request directs the inspector to sample the product "ham", in a plant that produces whole hams, center slices, butts, or shank portions from the same lot, what product does the inspector sample?

Answer: All products (hams, shank portions, butt portions, and slices) produced on one shift are treated as one lot for sampling purposes and the sample units selected are randomly chosen, regardless of their form.

4. **Question**: Can the inspector take more samples during periodic sampling at the processors request?

Answer: No.

5. **Question**: Does the computer make a determination as to which product will be sampled?

Answer: Yes, but with alternatives from the same Group. In the event the products or alternatives are not available, the forms are returned to Washington, D.C. and products from other Groups are not sampled.

6. **Question**: If only a partial lot is available for sampling, are the results of the sampling included in the determination of the Group/Product Values?

Answer: Yes.

7. **Question**: What does the term "periodic" mean as it applies to the sampling rate?

Answer: "Periodic" sampling means sampling at a rate other than daily. All plants start in periodic sampling.

8. **Question**: At what point in the process is a PFF product be sampled?

Answer: When it is ready to enter commerce, e.g., as a finished consumer ready unit.

9. **Question**: Does a sample represent all of the product produced in All Groups?

Answer: No. During periodic and daily sampling, it represents All products from the Group which it was selected.

10. **Question**: Is sampling increased during holiday periods?

Answer: Sampling rates are based on sample results, -- good results mean less sampling, bad results mean more sampling; however, production volume does affect sampling frequencies.

11. **Question**: For sampling purposes, should processors be encouraged to grind their samples rather than submitting a whole product unit as a sample?

Answer: No.

12. **Question**: Can the results from one sample put the plant into retention?

Answer: Yes, if that Sample PFF Value is equal to or less than the Absolute Minimum or if the Sample Value causes the Group Value and Product Value to fall below the Action Limits.

13. **Question**: Are plants allowed to devise a sampling plan for the retention phase which is different than the one which is included in the regulation?

Answer: Yes. The sampling plan must be as effective as the one specified in the regulation and must be approved by the Administrator prior to its use during the retention phase.

14. **Question**: Is a Group Value maintained for ham patties?

Answer: Yes. All products under the purview of this regulation will have a Group Value and a Product Value.

15. **Question**: Is a steam cooked product placed in the same Group as water cooked product?

Answer: Yes, if they are packaged the same.

16. **Question**: If a processor is producing a boneless cooked ham in an impervious casing, is it considered to be a Group I product?

Answer: Yes. Any product which is imperviously encased, is a Group I product no matter whether it is canned, in an impervious nylon casing, or in a plastic cook-in bag, boneless or bone-in.

17. **Question**: If one product goes into retention, can it be removed from the Group and monitored separately?

Answer: Yes. If the average production rate of the product over the 8-week period preceeding the week in which the retention occurred, is not greater than 20% of the rate of production of its Group.

18. **Question**: Can the inspector take action based on Product or Group Value results without input from the computer?

Answer: No. The inspector is not expected to keep track of the Product Values or the Group Values and does not take any action on Product Values or Group Values unless requested by the computer.

19. **Question**: If a processor keeps track of the Product Values and the Group Values, can the processor determine when retention of any given product is coming?

Answer: Yes. It is recommended that the processor keep informed of the Product Values and the Group Values, as determined by FSIS.

20. **Question**: If the processor maintains Group Value and Product Value charts with or without computer assistance, should the inspector use the processor's charts?

Answer: No.

21. **Question**: If a processor is producing several Groups of products and one Group goes into daily or retention phase sampling, how does this affect the sampling of the other Groups?

Answer: It does not.

22. **Question**: Does the inspector do any calculations associated with PFF compliance?

Answer: Yes. In plants using accredited laboratories, the inspector is expected to determine the PFF of the sample, and determine if the PFF of the sample is equal to or below the Absolute Minimum PFF. The inspector also determines the lot average PFF on retained lots and compare them to the applicable standards to determine if the retained product may be released or if it needs to be reprocessed or relabeled.

23. **Question**: What does "like product" mean?

Answer: "Like product" is product within the same group, meeting the same PFF standard, and bearing the same common and usual name.

24. **Question**: Are all boneless hams, even though the boneless hams may represent different quality levels, net weights, and brand names, considered to be a single product?

Answer: Yes. All products which are in the same Group and labeled with the same common and usual name are considered "like product."

III. RETENTION

1. **Question**: If a product is in retention and the Product Value is equal to or greater than zero, and all other parameters for getting out of retention are satisfied, but the variability of the process is still high, will the product remain in retention?

Answer: No.

2. **Question**: If a regular ham was found to be out of compliance with the standard and retention was initiated, does it affect the compliance of the water added hams?

Answer: No.

3. **Question**: Are the three samples taken during retention (to determine the lot average PFF) analyzed for PFF independently or will they be a composite sample?

Answer: Independently and results averaged.

4. **Question**: Is the variability among the three separate samples from the retained lot evaluated and used?

Answer: No.

5. **Question**: How are the three samples taken from retained lots evaluated?

Answer: The average of the three samples are used for determining the disposition of the lot. The average is entered into the appropriate Product and Group Value calculations. The PFF analyses of the individual samples are compared to the Absolute Minimum requirement, and utilized to determine when the product returns to daily sampling.

6. **Question**: During retention, does the five lot minimum reflect five days production or five shifts production?

Answer: Five consecutive shifts.

7. **Question**: Once the inspector has determined that the sample PFF is equal to or less than the Absolute Minimum, does the inspector begin retention activities?

Answer: Yes. In addition, the inspector has the responsibility to retain product.

8. **Question**: If a processor produces both canned ham and regular smoked ham, and one of the two goes into retention, are they both placed under retention?

Answer: No. These two products belong to different groups as defined by the regulation and the retention of one does not cause the retention of the other.

9. **Question**: What happens when the PFF of a sample is equal to or less than the Absolute Minimum?

Answer: The lot which is represented by the sample is retained and each subsequently produced lot of like product is placed under retention. The average PFF of each lot is determined and a decision is made to release, reprocess or relabel product.

10. **Question**: During retention of a product with four labels, how does the inspector sample the products? Is product with each of the four labels sampled?

Answer: Three samples are randomly selected under the retention phase. Therefore, all labels may not be sampled.

11. **Question**: If a processor's product goes into retention, can the PFF result (a single sample) that triggered the retention be the basis for calculating the shrink needed to bring the lot into compliance?

Answer: Once retention is triggered, a three sample average is necessary to determine an accurate lot average PFF upon which to base the decision on the disposition of the product; however, sampling alternatives will be considered if shown to be valid.

12. **Question**: How can retained product be released?

Answer: It must be sampled to determine the lot average PFF and may be released only if the lot average PFF is equal to or higher than the standard, otherwise it may be reprocessed until it meets the standard or be relabeled.

13. **Question**: If a retained lot has been sampled and one of the three samples is below the Absolute Minimum, but the lot average PFF equals the standard, can the lot be released?

Answer: Yes. Compliance of the retained lot is based upon the lot average PFF as determined by the three sample average. The three sample average must be equal to or higher than the applicable standard. However, the sample which is equal to or less than the Absolute Minimum could delay the return to the daily and periodic sampling phases from the retention phase.

14. **Question**: If canned ham is retained, can it be reprocessed or relabeled?

Answer: Yes.

15. **Question**: If a plant has a product that goes into retention, can the lot size then be reduced while the product is in retention status?

Answer: No. Lot sizes while in retention status must be substantially the same as they were prior to retention. The purpose of retention status is to make necessary process changes and demonstrate reestablishment of process control. If lot sizes are different, they are not representative of the process in question.

IV. ADDED PROTEINS

1. **Question**: How are the added proteins identified as added proteins?

Answer: By the inspector in the plant knowing about the addition of the protein containing ingredients and reporting them to the laboratories.

2. **Question**: How is the meat protein content of an additive determined when the inspector cannot determine the protein content of the additive?

Answer: The inspector informs the laboratory of the quantity of the additive used and that the protein level is unknown. The laboratory deducts the highest amount of protein which is known to exist in the additive being used.

3. **Question**: If the protein content of an additive varies; or an additive is reformulated to include more or less protein than the original formula, how does the inspector know which level of protein to report to the laboratory?

Answer: The processor is responsible for notifying the inspector if the protein content changes. The inspector informs the laboratory of the additive and the percentage content of protein. In addition, the inspector may request the laboratory to do a protein analysis on the pickle.

4. **Question**: If 0.5% protein is added to a cured pork product, is 0.5% protein deducted from the total protein to obtain the meat protein used in calculating the PFF?

Answer: All non-meat proteins are deducted on a finished product basis. Although unlikely, more than 0.5% may be deducted if the finished product yield is less than the green weight.

5. **Question**: If a protein-containing ingredient is used in a cured pork product and the label of the ingredient includes a statement as to the percent protein contained in the ingredient, is the label statement accepted as a declaration of protein content?

Answer: Yes, but that does not mean the inspector may not occasionally sample.

6. **Question**: If the processor does not use any protein additives, should the inspector note smokehouse and cooler shrink on the sample request form?

Answer: No.

7. **Question**: Are plants required to certify the amount of protein in added ingredients?

Answer: No. The inspector records the amount of the added ingredients containing proteins used in the products and the percent of protein found in the added ingredient if it is available. If the amount of protein in the added ingredient is not available to the inspector, the laboratory deducts the maximum percent of protein normally found in that ingredient.

8. **Question**: How are protein-containing flavorings added to curing solutions detected by the compliance system and subtracted from the total protein to provide the meat protein content?

Answer: All additives which contain protein--including flavorings--are reported to the laboratory by the inspector and noted on the sample request form so that they may be deducted from the total protein as added proteins. Sampling of additives in a pickle may occasionally be necessary.

9. **Question**: Is any credit for the loss of protein during cooking allowed by the PFF regulation?

Answer: No.

10. **Question**: Are substances such as pork broth, dried beef stock, etc., which are added for flavor or to enhance flavor, permitted in PFF controlled products?

Answer: Yes. However, the protein contributed by such ingredients is deducted when determining the PFF value.

V. QUALITY CONTROL

1. **Question**: Can a quality control program be established in a plant without having a quality control laboratory in the plant?

Answer: Yes.

2. **Question**: How often is sampling of products required in a quality control program?

Answer: There has not been any establishment of guidelines on the frequency of sampling in a PFF quality control program. Sampling frequencies must take into account such things as type of in-process controls, volume, variability, product lines, etc.

3. **Question**: How is the X in the X% product controlled?

Answer: By formulation and yield, i.e., in-plant control. However, laboratory analysis may supplement the control program. At a later date if laboratory analysis can be shown to be effective, it will be considered.

4. **Question**: If a product was labeled as "X%" of weight is added ingredients, "is variation allowed around the "X%"?

Answer: Some variation around the "X%" is allowed.

5. **Question**: Are guidelines on the preparation of a PFF quality control program available for use and distributed to industry?

Answer: Yes. Copies are available from the regional offices.

6. **Question**: Is a processor who has an approved quality control program included in the FSIS monitoring system specified in the PFF regulation?

Answer: No.

7. **Question**: Can the yield data be used as part of the process control rather than the compliance system established by the regulation?

Answer: Yes, if it is part of an approved QC program. Occasional verification sampling will be necessary.

8. **Question**: Are the control methods used in the PFF regulation adequate for use in a quality control program?

Answer: No. The approaches used in the PFF regulation would be acceptable for use in the TQC system or a PQC program, but the system used in the PFF regulation is a monitoring system and not a control system. So, a quality control program which mimics the PFF regulation is not adequate to control a process and is not acceptable.

9. **Question**: Who handles sampling for a TQC plant?

Answer: The plants, with one exception, i.e., the inspector may select verification samples to monitor the QC activity.

10. **Question**: Can data collected on past production be used to document the adequacy of a quality control system or program?

Answer: Yes, if the process is unchanged.

VI. LABORATORIES

1. **Question**: If a yield test indicates the product is in compliance, but the laboratory results indicate that the product is not in compliance, which result takes precedence?

Answer: The laboratory result takes precedence under the PFF compliance system.

2. **Question**: Are processors allowed to use accredited laboratories for fat and protein analyses?

Answer: Yes.

3. **Question**: Do inspectors receive results from the accredited labs?

Answer: Yes. The information flow between the inspector and the accredited labs has not changed.

VII. IMPORTS

1. **Question**: Are imported products subject to the same PFF standards?

Answer: Yes.

VIII. EXEMPTION

1. **Question**: Are cured pork products prepared under custom exemption subject to the PFF regulation?

Answer: No, because these products do not carry the mark of inspection.

2. **Question**: Are cured pork products prepared under retail exemption subject to the PFF regulation?

Answer: No, because these products do not carry the mark of inspection.

IX. STATE PROGRAMS

1. **Question**: How does the PFF regulation affect state inspected plants?

Answer: All cured pork products produced in state plants must comply with the PFF standards.

2. **Question**: Is a state plant a part of the PFF directed sampling and compliance system?

Answer: Yes, unless they have an approved quality control program.

X. PRODUCTS COVERED

1. **Question**: Are "canned deviled ham, or ham loaf, and ham sausage" covered by the PFF regulation?

Answer: No. The only comminuted products covered by the PFF regulation are those labeled as "ham patties", "chopped ham", "pressed ham", and "spiced ham".

2. **Question**: Are country hams, country style hams, dry cured hams, and country pork shoulders covered by the PFF regulation?

Answer: No. These products are covered under 319.106 of the regulations.

3. **Question**: Are bacon and miscellaneous cured pork products such as hocks, ears, snouts, feet, knuckles, tails, fat back and jowls covered by the PFF regulation?

Answer: No.

XI. OTHER

1. **Question**: Do processors need to continue submitting processing procedures for cured pork products to the inspector as they have under the current regulation?

Answer: Yes. The inspector must have the processing procedures to monitor the use of restricted ingredients and processing procedures.

2. **Question**: If an inspected and passed product is only being resmoked or sliced, is it subject to PFF sampling?

Answer: No, provided that the resmoked or sliced product bears the same common and usual name and qualifying statement (if any) as the initial product.

3. **Question**: Since FSIS permits "down labeling" under PFF, can all products be down labeled to an X % product?

Answer: No. Only products produced to meet the water added requirement may be down labeled to an X % product. Products such as ham or ham with natural juices may not be down labeled to an X % product.

4. **Question**: Is labeling approved for less than 20 % added ingredients for an X % product?

Answer: No. However, labels submitted with less than 20 % added ingredients are evaluated on a case-by-case basis.

5. **Question**: Is collagen or other proteinaceous material, used for any purpose such as an outer wrapping or coating, deducted as an added meat protein?

Answer: Yes.

6. **Question**: Is a cured pork product that is subject to the PFF regulation but contains poultry regulated under PFF?

Answer: Yes. The protein contributed by the poultry is not deducted to determine the PFF.

7. **Question**: Can two samples be collected from the same group on the same day?

Answer: No.

8. **Question**: How are Talmadge-Aiken plants treated under the PFF regulation?

Answer: The same as any other federally inspected plant.

XII. NEW STATEMENTS

1. **Question**: Is there an alternature to the size requirement for the qualifying statement labels for cured pork products?

Answer: Yes. An alternative to the 3/8 inch letter size requirement is that the qualifying statement must be at least 1/3 the size of the common and usual name in the same color and style print as the product name and on the same color background.

2. **Question**: Must products be labeled the full length of the product with a qualifying statement?

Answer: No.

3. **Question**: Since PFF accounts for all added substances in a cured pork product, is there any need to limit the use of liquid or solid sweeteners added to chopped ham as the PFF regulations require?

Answer: No.

ATTACHMENT A

TABLE TO DETERMINE X% ON RETAINED PRODUCT LABEL WHEN FAT AND PFF ARE KNOWN

	PFF													
%FAT	10.0	10.5	11.0	11.5	12.0	12.5	13.0	13.5	14.0	14.5	15.0	15.5	16.0	16.5
UP TO														
0.5	35	35	35	35	30	30	30	30	25	25	25	25	20	20
3.5	35	35	35	35	30	30	30	30	25	25	25	20	20	20
4.0	35	35	35	30	30	30	30	30	25	25	25	20	20	20
8.5	35	35	35	30	30	30	30	25	25	25	25	20	20	20
9.0	35	35	30	30	30	30	30	25	25	25	25	20	20	20
10.0	35	35	30	30	30	30	30	25	25	25	20	20	20	20
13.0	35	35	30	30	30	30	25	25	25	25	20	20	20	20
15.5	35	30	30	30	30	30	25	25	25	25	20	20	20	15
16.5	35	30	30	30	30	25	25	25	25	25	20	20	20	15
17.0	35	30	30	30	30	25	25	25	25	20	20	20	20	15
20.5	30	30	30	30	30	25	25	25	25	20	20	20	20	15
22.0	30	30	30	30	25	25	25	25	25	20	20	20	20	15
22.5	30	30	30	30	25	25	25	25	25	20	20	20	15	15
25.0	30	30	30	30	25	25	25	25	20	20	20	20	15	15
28.0	30	30	30	25	25	25	25	25	20	20	20	20	15	15
28.5	30	30	30	25	25	25	25	20	20	20	20	20	15	15
29.5	30	30	25	25	25	25	25	20	20	20	20	20	15	15
32.0	30	30	25	25	25	25	25	20	20	20	20	15	15	15
32.5	30	25	25	25	25	25	25	20	20	20	20	15	15	15
35.5	30	25	25	25	25	25	20	20	20	20	20	15	15	15
36.5	25	25	25	25	25	25	20	20	20	20	15	15	15	15
40.5	25	25	25	25	25	20	20	20	20	20	15	15	15	15
41.0	25	25	25	25	20	20	20	20	20	20	15	15	15	15
43.5	25	25	25	25	20	20	20	20	20	15	15	15	15	15
45.0	25	25	25	20	20	20	20	20	20	15	15	15	15	15
45.5	25	25	25	20	20	20	20	20	20	15	15	15	15	10
46.5	25	25	25	20	20	20	20	20	15	15	15	15	15	10
49.0	25	25	20	20	20	20	20	20	15	15	15	15	15	10
50.0	25	20	20	20	20	20	20	15	15	15	15	15	15	10

UNITED STATES DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
WASHINGTON, D.C.

CHANGE TRANSMITTAL SHEET

☒ DIRECTIVE
☐ REVISION
☒ AMENDMENT
☐ OTHER

FSIS DIRECTIVE
STANDARDS AND LABELING DIVISION
POLICY MEMORANDA

7220.1
Amend. 13

3-13-86

I. PURPOSE

This document transmits changes to FSIS Directive 7220.1.

II. CHANGES

Insert Policy Memo 094 in numerical order in Attachment 1 of FSIS Directive 7220.1.

III. CANCELLATIONS

This change transmittal is cancelled when contents have been incorporated.

Margaret OK Glavin
Director
Standards and Labeling Division
Meat and Poultry Inspection Technical Services

Attachment

DISTRIBUTION: All MPI Offices, T/A Inspectors, Plant Management, T/A Plant Management, Science and Compliance Offices, Import Offices, R&E, ABB

OPI: MPITS/Standards and Labeling Division

United States
Department of
Agriculture

Food Safety
and Inspection
Service

FEB 10 1986

To: Branch Chiefs
SLD

Policy Memo 094

From: Margaret O'K. Glavin, Director
SLD

Subject: Sulfiting Agents

ISSUE: Whether sulfiting agents present in processed fruits or vegetables used as ingredients of meat food products or poultry food products need to be declared on the label of the finished product.

POLICY: The presence of sulfiting agents (sulfur dioxide, potassium bisulfite, potassium metabisulfite, sodium bisulfite and sodium metabisulfite) in or on processed fruits or vegetables used as ingredients of meat food products or poultry food products must be declared on the label of the finished product.

RATIONALE: The addition of sulfurous acid and salts of sulfurous acid directly to meat food products is prohibited by regulation (9 CFR 318.7(d)(2)). However, these ingredients and other sulfiting agents may be present in or on processed fruits or vegetables that are used as ingredients of meat food products or poultry food products. Sulfiting agents on fruits or vegetables in meat or poultry food products may pose a health risk to certain individuals who are susceptible to them. The Agency plans to amend the above regulation to clarify that the sulfiting agents used in a USDA inspected meat or poultry product must be declared on the finished product label. In the interim, in order to facilitate avoidance of these ingredients in meat or poultry food products by susceptible consumers, the Standards and Labeling Division (SLD) is implementing this labeling policy.

UNITED STATES DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
WASHINGTON, D.C.

FSIS DIRECTIVE | 7231.2 | 3-7-86

REPORTING OF OBSOLETE LABELS

I. PURPOSE

This directive states the procedures for FSIS inspectors to follow to report labels no longer in use.

II. CANCELLATION

(RESERVED)

III. REASON FOR REISSUANCE

(RESERVED)

IV. REFERENCES

Section 317.14 of the meat inspection regulations and section 381.141 of the poultry products inspection regulations.

V. FORMS AND ABBREVIATIONS

SLD - Standards and Labeling Division

VI. INSPECTOR RESPONSIBILITIES

When the inspector is notified by plant management that a product label is no longer in use, or when the inspector is notified by SLD that a label is no longer approved, the inspector shall:

1. Remove the transmittal sheet, which has the official label approval number on it, from the official file, date it, write "Rescinded" on the sheet and forward it to SLD.

2. Remove the label and any other copies of the transmittal sheet from the official file and return them to plant management.

Deputy Administrator
Meat and Poultry Inspection Operations

DISTRIBUTION: All MPI Offices, T/A Inspectors, Plant Management, T/A Plant Management, Science and Compliance Offices, Import Offices, R&E, TRA, ABB

OPI: Standards and Labeling Division, MPITS

UNITED STATES DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
WASHINGTON, D.C.

CHANGE TRANSMITTAL SHEET

☒ DIRECTIVE
☐ REVISION
☐ AMENDMENT
☐ OTHER

FSIS DIRECTIVE 7231.3, CONTROL AND USE OF LABELS	7231.3	3-19-86

I. PURPOSE

This document transmits FSIS Directive 7231.3 and provides instructions to users regarding deletion of a section of the Meat and Poultry Inspection Manual.

II. INSTRUCTIONS

The attached directive supersedes section 17.5 of the Meat and Poultry Inspection Manual. Please cross out this section in your Manual and note therein that the current instructions are contained in FSIS Directive 7231.3.

III. CANCELLATION

This change transmittal is cancelled when contents have been filed and Meat and Poultry Inspection Manual maintenance instructions outlined above have been completed.

James K. Payne for
Deputy Administrator
Meat and Poultry Inspection Operations

Attachment
FSIS Directive 7231.3

DISTRIBUTION: All MPI Offices, T/A Inspectors, Plant Management, T/A Plant Management, Science and Compliance Offices, ABB, TRA, R&E, Import Offices

OPI: Standards and Labeling Division, MPITS

UNITED STATES DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
WASHINGTON, D.C.

FSIS DIRECTIVE

7231.3

3-19-86

CONTROL AND USE OF LABELS

I. PURPOSE

This directive provides instructions to inspectors to assure that labels are used only on products for which they are approved, including labels bearing origin claims. This directive also provides information concerning the procedures to be followed when labels are shipped between official establishments.

II. CANCELLATION

Section 17.5 of the Meat and Poultry Inspection Manual.

III. REASON FOR REISSUANCE (RESERVED)

IV. REFERENCES

Parts 316, 317, 318 and 319 of the Federal meat inspection regulations; and Part 381 of the poultry products inspection regulations.

V. PROCEDURES

A. Inspector Control of Approved Labels

To assure labeling compliance with the regulations and the approved product formulation and processing, the inspector should require plant management to have adequate procedural controls. However, such procedural controls must not significantly surpass normal routine controls needed to assure product compliance. Approved "partial quality control" programs should be utilized wherever necessary to assure the accuracy of information shown on approved labels such as the net weight, vignette, and origin and nutrition claims. The inspector shall assure that a label offered for use at an official establishment is:

1. Approved in accordance with the regulations.

2. Used only on the product for which it was approved.

DISTRIBUTION: All MPI Offices, T/A Inspectors, Plant Management, T/A Plant Management, Science and Compliance Offices, ABB, TRA, R&E, Import Offices

OPI: MPITS, Standards and Labeling Division

3. Placed on the product or its container so that the labeling information required on the principal display panel is shown properly.

4. Provides sufficient contrast in background color so that the labeling information on transparent coverings is prominently displayed.

5. Printed with permanent ink and all required information is clearly legible.

6. Does not cause product to become adulterated or contaminated. For example, water or fat-soluble ink may be transferred to the product; or the paper label may disintegrate or contain soluble components that may contaminate the product.

B. Use of Labels Bearing Origin Statements

1. An approved label bearing a product or ingredient origin statement may be used by an official establishment only after the inspector determines that the statement is accurate. If the inspector is unable to verify the accuracy of the statement, he or she shall withhold use of the label.

2. A processor who obtains live poultry from several States and wishes to use a geographical origin statement on the approved product label must keep the live poultry and resulting product segregated. In addition, the inspector should be furnished with acceptable evidence of the origin of the live poultry (such as a statement from the grower, shipping papers, sales slip, etc.) so that the accuracy of the approved label can be verified. When the geographical origin of the product cannot be verified, the inspector shall withhold use of the approved label.

C. Transfer of Approved Labels Between Official Establishments

When the inspector-in-charge (IIC) of one official establishment authorizes the shipment of labels, wrappers, or containers bearing the official mark (with or without the establishment number) to another official establishment, the IIC of the originating establishment shall prepare three copies of MP Form 441, Permit to Ship Meat or Poultry Labels Between Official Establishments. The original MP Form 441 and a copy of each label will be mailed to the IIC at the authorized destination. The duplicate of the MP Form 441 and one copy of each label will accompany the shipment. The third copy of the MP Form 441 and one copy of each label will be retained in the IIC's files at the originating establishment.

Deputy Administrator
Meat and Poultry Inspection Operations

UNITED STATES DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
WASHINGTON, D.C.

FSIS DIRECTIVE

7350.1

3-6-86

CONTAMINATION OF PRODUCTS

I. PURPOSE

This Directive provides instruction for inspection personnel to follow when meat and poultry products have been contaminated by foreign particulate materials such as metal, plastic, rubber, or glass.

II. RESERVED

III. REFERENCES

Meat and Poultry Inspection Mannual, Section 8.31
Meat and Poultry Regulations Sections 308.5, 310.18, 318.2(d), 381.53, 381.78(a) and 381.91
21 CFR 179.21--FDA Regulation

IV. POLICY

FSIS has responsibility for assuring that meat and poultry products produced under the Federal Meat Inspection Act and the Poultry Products Inspection Act are safe, wholesome and unadulterated.

V. DETECTION EQUIPMENT GUIDELINES

A. While not mandatory in normal production, FSIS encourages the use of contamination detection equipment by establishments. All detection equipment must be acceptable to the Facilities, Equipment and Sanitation Division (FESD), Equipment Branch as set forth in Section 308.5 of the regulations.

B. To be found acceptable for the purpose of examining and reprocessing known contaminated product, equipment must be capable of detecting contamination particles of 1/32" or less. Prior to the detection operation, such detection equipment must be tested with seeded samples at the same rate of speed that will be used to process the contaminated product. At the discretion of the inspector, the same process can be tested 2-4 times per hour during the actual operation of processing the contaminated product.

DISTRIBUTION: All MPI Offices, T/A Inspectors, Plant Management, T/A Plant Management, Science and Compliance Offices, Import Offices, R&E, TRA, ABB

OPI: MPITS/Processed Products Inspection Division

C. X-RAY DETECTION EQUIPMENT

1. X-ray equipment has special safety requirements as follows:

(a) The equipment must comply with Food and Drug Regulations 21 CFR 179.21. This regulation states, in part, that the radiation source must be X-ray tubes producing X-radiation from operation of the tube source at energy levels of 300 kilovolt peak or lower.

(b) The equipment shall bear a label identifying the source of radiation and maximum energy of radiation emitted by X-ray tube sources. This label or accompanying labeling material must also bear (1) adequate directions for installation and use, and (2) a statement that no food shall be exposed to the radiation sources listed above so as to receive an absorbed dose in excess of 1,000 rads.

2. Some State and local laws require plant employees and plant inspectors to wear radiation monitoring badges when working in the x-ray inspection area. Safety badges are **ALWAYS** available to inspection personnel through the Regional Office.

3. If a TV-type screen is used to monitor products for contamination, inspectors monitoring the screen must be relieved every 20 minutes or less to avoid eye/body fatigue, reducing the chance of missing visual detail.

VI. PROCEDURAL GUIDE FOR CONTAMINATED PRODUCT

A. When product is discovered to be contaminated, it must be either reprocessed or rejected and will be segregated from the product that is acceptable. At the inspector's discretion, seeded samples may be processed through the screening operation without knowledge of the operator who monitors the process, thereby verifying the ability of both the equipment and the operator to detect the contamination.

B. If the operator/equipment monitoring the process is unable to identify the seeded sample, all contaminated product reprocessed after the last identified seeded sample must be rerun. If the operators/equipment fail repeatedly, reprocessing of contaminated product will cease.

VII. RESPONSIBILITIES

A. The Inspectors-in-Charge shall:

1. Retain all suspect contaminated product, and supervise the destruction of that product which is still contaminated after the sorting and reconditioning procedure.

2. Secure notification from the establishment of their reprocessing plan, prior to any reprocessing which must comply with Section V and VI.

3. Furnish a written report of each particle contamination incident to include the confirmation of the establishment's procedure to the Regional Director through proper supervisory channels. (A separate report should **not**

be submitted to the Regional Director if the establishment elects to destroy the entire lot or code of contaminated product.) The inspectors' report will include the following information:

a. Description of the product.
b. Name of contaminant.
c. How contamination occurred.
d. Date contamination occurred.
e. Lots or codes involved.
f. Action by inspector.
g. Action/reaction by establishment.
h. Present status and location of product.
i. Recommendation for sorting, reconditioning and/or disposition of the product.

4. Monitor all aspects of the detection or reprocessing operation to include the adequacy and competency of personnel furnished by the establishment according to its approved plan.

5. Review with the establishment the steps they will take to assure that the chances of future incidents of contaminated product will be minimal.

B. **The Circuit Supervisor/Area Supervisor shall:**

1. Review contamination report from the inspector and the establishments procedure.
2. Assure that description of incident is accurate and adequate.
3. Assure that establishment has taken reasonable steps to prevent future incidents.
4. Make recommendations to the Regional Director.

C. **The Regional Director shall:**

1. Review the contamination report and recommendations submitted by the IIC, Circuit Supervisor, and Area Supervisor.

2. Review the establishments processing procedure.

3. Make the final decision regarding disposition of the product.

4. Coordinate with Processed Products Inspection Division (PPID) or Inspection Operations (MPIO) if there are unusual circumstances involved or guidance is desired.

Act Deputy Administrator
Meat and Poultry Inspection Operations

UNITED STATES DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
WASHINGTON, D.C.

FSIS DIRECTIVE

9225.2

4/30/86

EXPORT OF FRESH/FROZEN POULTRY TO THE UNITED KINGDOM

I. PURPOSE

The purpose of this directive is to describe requirements for the export of fresh/frozen poultry for human consumption to the United Kingdom from the United States.

II. CANCELLATION

Paragraph 22.39(b)(2)(1), Meat and Poultry Inspection Manual; FSIS Notice 8-85.

III. (RESERVED)

IV. REFERENCES

A. Sections 22.31-A and 22.39, Meat and Poultry Inspection Manual.

B. Current plant list published as an FSIS Notice: "Poultry Plants Eligible to Export to the United Kingdom."

V. FORMS AND ABBREVIATIONS

The following will appear as abbreviated in this directive:

EEC	European Economic Community.
UK	United Kingdom.
MP Form 31	Establishment Application for Export of Meat/Poultry (1/83 or newer).
MP Form 40	Health Certificate for Fresh Poultry Meat Intended for Consignment to a Member State of the EEC. (1/85 or newer).
MP Form 130	Meat and Poultry Certificate of Wholesomeness (5/80 or newer).
MP Form 412-14	Veterinary Certificate for Export of Poultry (1/85 or newer).

DISTRIBUTION: All MPI Offices, T/A Inspectors, Plant Management, T/A Plant Management, Science and Compliance Offices, Import Offices, R&E, TRA **OPI:** IP/ECD

VI. GENERAL REQUIREMENTS

A. Eligible Plants.

1. Approved Plant List. Refer to the current FSIS Notice, "Poultry Plants Eligible to Export to United Kingdom," which specifies plant currently certified as eligible to export to the United Kingdom.

2. Plant Approval.

a. Poultry slaughter and cutup plants that desire to apply for approval to export to the United Kingdom must meet EEC and UK requirements specified in Sections 23.31-A and 22.39, respectively, of the Meat and Poultry Inspection Manual.

b. Plants that meet requirements and wish to be approved for export to the United Kingdom must submit an application--MP Form 31--through the Regional Director to the Deputy Administrator, International Programs. See Attachment 1.

B. **Eligible Product**. The definition of "fresh poultry" for the United Kingdom includes frozen carcasses, and cutup poultry. Carcasses must be fully eviscerated and not contain or be accompanied by necks and giblets.

C. **Certification**. All certificates and supplementary statements must be signed by a FSIS veterinarian. Issue the following forms:

1. Commercial shipments. Issue the following forms:

a. MP Form 130. See Attachment 2.

b. MP Form 40. See Attachment 3. Fill in Block II, Origin of the Meat, as follows:

(1). The establishment number and address of the slaughterhourse must be filled in, in all cases.

(2). The establishment number and address of the cutting plant must be filled in for product other than whole carcasses.

c. MP Form 412-14. See Attachment 4. To enable proper completion of the form:

(1). Item 1.b.: The official establishment and/or the flock management will be required to provide written certification by their veterinarian to the official veterinarian at the slaughter establishment as follows:

"I certify that the poultry originated from flocks under veterinary supervision in which, within the preceding two months, none of the following diseases have been diagnosed - Fowl Plague, Newcastle Disease, Salmonellosis, Fowl Cholera (Pasteurellosis) and Ornithosis, and, as applicable to ducks, geese, or turkeys, Duck Virus Hepatitis, Goose Influenza, or Paracolon Arizona Infection."

(2). Item 1.d.: Inspectors in charge must contact the nearest Veterinary Services office to determine the status of velogenic Newcastle disease as specified in item 1.d., that is;

"The poultry were hatched, reared, and slaughtered in a state in which, after due inquiry, I am satisfied that no outbreak of a velogenic strain of Newcastle disease has been recorded in the six months prior to slaughter."

2. U.S. Armed Forces shipments. Issue:

a. MP Form 130. See Attachment 2.

b. MP Form 412-14. See Attachment 4. To complete the form properly, follow the same instructions specified for commercial shipments in subparagraph C.1.c.

D. **Special Marking Requirements for Product, Wrapping, and Packaging.** Poultry meat and/or wrapping and packaging materials of poultry product must bear the USDA official poultry inspection legend as follows:

1. Packages of bulk product of carcasses, parts, or giblets destined for further processing in the United Kingdom must bear the inspection legend and the intended use label as described in subparagraph E. Bulk product:

a. Is exempt from individual marking and wrapping.

b. Polywrappers (lining or bags) are not required to bear the inspection legend.

2. Individual carcasses must bear the legend on the wrapping or on the carcass in such a manner that it is clearly visible under the wrapping, and also on any packaging.

3. Wrapping and packaging of individuals cuts of poultry meat and giblets must bear the legend.

4. Poultry or poultry products, other than described above, must bear the legend applied both:

a. To the product or to the wrapper.

b. To any packaging thereof.

5. In all cases where the legend has been applied to packaging, or is printed on packaging, it shall have been applied or printed in such a manner so that the legend shall be destroyed when the package is opened, unless the packaging is not capable of being used again as packaging.

E. Special Label Requirement for Bulk Product (Intended Use Label). Packages of bulk product for further processing must bear an intended use label, to appear as follows:

Intended Use: Cutting/Treatment /1/ Added of Destination

/1/. Delete the word "cutting" or "treatment", as appropriate.

F. Required Use of Labels and Markings.

1. Bulk product. Shipping containers must bear the following:

a. Mandatory USDA labeling.

b. The legend mark which will be destroyed on opening. See subparagraph D.5.

c. The intended use label.

2. Consumer packages. Consumer packages and their shipping containers must bear the following:

a. Mandatory USDA labeling.

b. The legend mark which will be destroyed on opening. See subparagraph D.5.

NOTE: Consumer items in wrapping only must comply only with the wrapping requirement.

G. Wrapping and Packaging.

1. A wrapper or wrapping is defined as that material which contacts the poultry or giblets.

2. If wrapping material is used, it must be transparent and colorless unless it fulfills all of the protective requirements of packaging thereby becoming packaging material.

3. A package or packaging is the outer container of any material into which the poultry product is placed. This does not include a bulk container which is part of a road vehicle.

4. Bulk product for further processing applies in the following cases:

a. Bulk packages of carcasses consigned from a poultry slaughterhouse to:

(1). A poultry cutting plant.

(2). A restaurant, institution, etc., for direct supply to the final consumer after the poultry has been heat treated.

b. Bulk packages of carcasses consigned from a poultry cutting plant to a poultry products plant for heat treatment.

c. Bulk packages of poultry parts or giblets consigned from a poultry slaughterhouse or cutting plant to a poultry products plant for heat treatment.

This information must be used in conjunction with the requirements specified in Section 22.39 of the Meat and Poultry Inspection Manual and other notifications pertaining to the United Kingdom.

Deputy Administrator
Meat and Poultry Inspection Operations

Attachments
1. MP Form 31
2. MP Form 130
3. MP Form 40
4. MP Form 412-14

UNITED STATES DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
MEAT AND POULTRY INSPECTION OPERATIONS

ESTABLISHMENT APPLICATION FOR EXPORT OF

☐ **Meat** ☒ **Poultry**

1. DATE OF REQUEST
May 14, 1985

2. COUNTRY *(To which product will be exported)*
United Kingdom

3. TO *(Enter name of Director, Meat and Poultry Inspection Region, USDA, FSIS)*
Name of Director
Address of Regional Office

4. THRU *(Enter name of Area Supervisor, Meat and Poultry Inspection, USDA, FSIS)*
Name of Area Supervisor
Address of Area Office

5. FROM *(Establishment name and physical location of plant)*

Batesville Poultry, Inc.
706 Center
Batesville, AR 72503

6. USDA ESTABLISHMENT NO.
P-42

7. TYPE OF OPERATION *(Check)*

- ☒ Slaughter
- ☐ Processing
- ☒ Cut-up
- ☐ Grinding
- ☐ Curing
- ☐ Canning
- ☒ Cooking
- ☐ Smoking
- ☐ Rendering

8. CLASS OF PRODUCT TO BE EXPORTED *(Check)*

- ☐ Canned
- ☒ Cooked
- ☐ Cured
- ☒ Fresh/Frozen
- ☐ Offal
- ☐ Rendered
- ☐ 100 grams to 3 Kg cuts of meat

OTHER *(Specify type)*

9. The undersigned requests that the firm identified in Item 5 be included on the list of establishments certified by USDA as meeting the requirements of the country specified with respect to the importation of meat, meat products, or poultry.

We make this request with the understanding that, in addition to compliance with normal U.S. inspection requirements, the above-named firm voluntarily agrees to the following:

- To comply with all provisions of appropriate inspection laws and regulations of the importing country when preparing product for export to that country. These requirements have been outlined to officials of this firm by responsible FSIS personnel and are fully understood.
- To reimburse USDA for any inspections over and above U.S. requirements.
- To segregate and maintain identity of product eligible for export from noneligible product, when required.
- To notify appropriate U.S. inspection officials promptly when firm wishes to be removed from the list of plants that are eligible to export to the country named herein *(Item 2)*.

SPECIMEN

10. SIGNATURE OF AUTHORIZED FIRM REPRESENTATIVE
Larry Blakney

11. TITLE
Plant Manager

12. DATE SIGNED
5/14/85

I surveyed the above-named establishment on the date indicated below and, in my opinion, it meets the requirements for export to United Kingdom *(Name of Country)*, subject to comments if any on the attached Technical Memorandum.

13. SIGNATURE OF CIRCUIT SUPERVISOR
(Signature)

14. DATE ESTABLISHMENT SURVEYED
(Date)

CONCURRENCE

15. SIGNATURE OF AREA SUPERVISOR
(Signature)

16. SIGNATURE OF REGIONAL DIRECTOR
(Signature)

CERTIFIED FOR EXPORT

17. SIGNATURE OF DEPUTY ADMINISTRATOR, IP
(Signature)

18. DATE CERTIFIED
(Date)

MP FORM 31 (1/83) PREVIOUS EDITIONS ARE OBSOLETE

FOOD SAFETY AND INSPECTION SERVICE
MEAT AND POULTRY INSPECTION OPERATIONS

MEAT AND POULTRY EXPORT CERTIFICATE OF WHOLESOMENESS

A knowingly false entry or false alteration of any entry on this certificate may result in a fine of not more than $10,000 or imprisonment for not more than five years or both (18 USC 1001). Additional penalties exist under the Federal Meat Inspection Act [21 USC 611 (b) (1), (2), and (5), 21 USC 676] and the Poultry Products Inspection Act [21 USC 458 (c) (1), (2), and (3), 21 USC 461] for an unauthorized or false alteration or misuse of this certificate.

AREA OFFICE: Springdale, Arkansas

COUNTRY OF DESTINATION: United Kingdom

DATE ISSUED: February 20, 1986

MPA- 811005

EXPORTED BY *(Applicant's name and address including ZIP Code)*

Batesville Poultry, Inc.
706 Center
Batesville, AR [illegible]

CONSIGNED TO *(Name and address, including ZIP Code)*

London Provision Co.
2907 Sterling Rd.
London, England Zip

PRODUCT EXPORTED FROM:

EST/PLANT NUMBER *(If applicable)*: P-42

CITY: Batesville, Arkansas

☒ @ SLAUGHTERING PLANT
☐ @ PROCESSING PLANT
☐ @ WAREHOUSE
☐ @ DOCKSIDE

TOTAL MARKED NET WEIGHT: 4602 Lbs.
2087.4 kg.

TOTAL CONTAINERS: 767

PRODUCT AS LABELED	MARKED WEIGHT OF LOT 1/	NUMBER OF PACKAGES IN LOT 1/	SHIPPING MARKS 1/	EST/PLANT NUMBER ON PRODUCT
Frozen Whole Chicken Legs	4602 lbs. 2087.4 kg.	767	6238/FLST	P-42

1/As stated by applicant or contractor

REMARKS

SPECIMEN

☐ **I CERTIFY that the meat or meat food product specified hereon is from animals that received both antemortem and postmortem inspection and were found sound and healthy and that it has been inspected and passed as provided by law and regulations of the Department and is sound and wholesome.**

☒ **I CERTIFY that the poultry and poultry products specified above came from birds that were officially given an antemortem and postmortem inspection and passed in accordance with applicable laws and regulations of the United States Department of Agriculture and are wholesome and fit for human consumption.**

NOT VALID UNLESS SIGNED BY AN INSPECTOR OF MEAT AND POULTRY INSPECTION PROGRAM

By order of the Secretary of Agriculture

INSPECTOR AND CIRCUIT NUMBER: Emily Czarnik, DVM, 302-02
Emily Czarnik, DVM, 302-02

This certificate is receivable in all courts of the United States as prima facie evidence of the truth of the statements therein contained. This certificate does not excuse failure to comply with any of the regulatory laws enforced by the United States Department of Agriculture.

MP FORM 130 (2/85)

ATTACHMENT 3

U.S. DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
MEAT AND POULTRY INSPECTION PROGRAM

HEALTH CERTIFICATE FOR FRESH POULTRY MEAT INTENDED FOR CONSIGNMENT TO A MEMBER STATE OF THE EEC

SERIAL NO. OF MP FORM 130
MPA 811005

Fresh poultry meat is the fresh/frozen meat coming from the following species: chickens, turkeys, ducks, geese or guineas that have not undergone any treatment of a nature to assure their preservation; however, poultry meat which has been chilled or frozen shall be considered as fresh.

COUNTRY OF DESTINATION
United Kingdom

MINISTRY
U.S. DEPARTMENT OF AGRICULTURE

EXPORTING COUNTRY
UNITED STATES OF AMERICA

COMPETENT SERVICE
FOOD SAFETY AND INSPECTION SERVICE

I. IDENTIFICATION OF MEAT

MEAT OF *(Animal species)*
Chickens

NATURE OF CUTS
Frozen whole chicken legs

NATURE OF THE PACKAGING
Cartons

NUMBER OF PACKAGES
767

NET WEIGHT
4602 lbs.

II. ORIGIN OF MEAT

ADDRESS(es) AND ESTABLISHMENT NUMBER(s) OF THE APPROVED SLAUGHTERHOUSE(s) (1)

P-42 Batesville Poultry, Inc.
706 Center
Batesville, AR 72503

ADDRESS(es) AND ESTABLISHMENT NUMBER(s) OF THE APPROVED CUTTING PLANTS (1)

P-42 Batesville Poultry, Inc.
706 Center
Batesville, AR 72503

III. DESTINATION OF MEAT

THE MEAT WILL BE SENT FROM *(Place of loading)*
Batesville, Arkansas

TO *(Country and place of destination)*
United Kingdom
London, England

BY THE FOLLOWING MEANS OF TRANSPORT (2)
Ship - Koln Express

NAME AND ADDRESS OF CONSIGNOR

Batesville Poultry, Inc.
706 Center
Batesville, AR 72503

NAME AND ADDRESS OF CONSIGNEE

London Provision Co.
2907 Sterling Rd.
London, England ZIP

SPECIMEN

IV. HEALTH ATTESTATION

I, the undersigned official veterinarian, certify that:

(a) - the poultry meat described (1)
- the packaging of the meat described above (1)

bears a mark proving that
- the meat comes from animals slaughtered in approved slaughterhouses (1);
- the meat was cut in approved cutting premises (1);

(b) this meat has been passed as fit for human consumption following a veterinary inspection carried out in accordance with the Council Directive of 15 February 1971 on health problems affecting trade in fresh poultry meat;

(c) the transport vehicles or containers and the loading conditions of this consignment meet the hygiene requirements laid down in that Directive.

(1) Delete as appropriate.
(2) For railway wagons and lorries the registration number, for aircraft the flight number and for ships the name should be given.

DONE AT
Batesville, Arkansas

ON *(Date)*
February 20, 1986

SIGNATURE OF OFFICIAL VETERINARIAN
Emily Czarnik, DVM, 302-02
Emily Czarnik, DVM, 302-02

[illegible]

U.S. DEPARTMENT OF AGRICULTURE FOOD SAFETY AND INSPECTION SERVICE MEAT AND POULTRY INSPECTION OPERATIONS **VETERINARY CERTIFICATE FOR EXPORT OF POULTRY**	SERIAL NO. OF MP FORM 130 MPA 811005

IDENTIFICATION OF PRODUCT

KIND (chicken, turkey, duck, etc. without offal) Chicken		CLASS (broiler, fryer, roaster, etc.) Broilers
NO. OF PACKAGES 767	NET WEIGHT 4602 lbs.	IDENTIFICATION MARKS 6238/FLST
DESCRIPTION OF ITEM (carcass, parts, or offal) Frozen Whole Chicken Legs		ESTABLISHMENT NO., NAME, AND ADDRESS OF SLAUGHTERHOUSE P-42 Batesville Poultry, Inc. 706 Center Batesville, AR 72503

SPECIMEN

I, a veterinary officer duly designated by the United States Government, certify that:

1. The whole of the consignment described above was derived from poultry which:

a. were subject at the slaughterhouse named above to ante-mortem inspection by an authorized veterinary officer and to post-mortem inspection under the supervision of an authorized veterinary officer and no sign of infectious disease was detected;

b. originated from flocks under veterinary supervision in which, within the preceding two months, none of the following diseases have been diagnosed – Fowl Plague, Newcastle Disease, Salmonellosis, Fowl Cholera (Pasteurellosis) and Ornithosis, Duck Plague (see notes 1 and 2), and Duck Virus Hepatitis (see note 1), Goose Influenza (see note 2), Paracolon Arizona infection (see note 3).

c. have not been in contact at the slaughterhouse with any other poultry in which any of the diseases mentioned in (b) above have been diagnosed.

d. were hatched, reared, and slaughtered in a state in which, after due inquiry, I am satisfied that no outbreak of a velogenic strain of Newcastle disease has been recorded in the six months prior to slaughter.

2. The poultry carcasses are fully eviscerated and do not contain nor are accompanied by any offal.

NOTES:

1. Certification in respect of these conditions is required additionally for any permitted import of carcasses or parts of carcasses derived from ducks.
2. Certification in respect of these conditions is required additionally for any permitted import of carcasses or parts of carcasses derived from geese.
3. Certification in respect of this condition is required additionally for any permitted import of carcasses or parts of carcasses derived from turkeys.

DATE February 20, 1986	SIGNATURE OF OFFICIAL VETERINARIAN Emily Czarnik, DVM, 302-02 Emily Czarnik, DVM, 302-02

MP FORM 412-14 (1/85) REPLACES MP FORM 412-14 (8/81), WHICH IS OBSOLETE.

UNITED STATES DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
WASHINGTON, D.C.

FSIS DIRECTIVE

9225.1

4-24-86

EXPORT MARKING REQUIREMENTS OF PRODUCT, WRAPPING, AND PACKAGING FOR MEAT PRODUCT TO THE UNITED KINGDOM

I. PURPOSE

This directive describes requirements for the marking of product, wrapping, and packaging of meat product for human consumption destined for the United Kingdom from the United States.

II. CANCELLATION

FSIS Notice 18-85.

III. (RESERVED)

IV. REFERENCES

Section 22.39 of the Meat and Poultry Inspection Manual.

V. (RESERVED)

VI. GENERAL REQUIREMENTS

A. **Marking Product and its Wrapping and Packaging.** Product from cattle, swine, sheep, goats, and equines and/or the wrapping and packaging materials of the product must bear the mark of the USDA official inspection legend as follows:

1. Cattle, swine, and equine livers must be branded with a hot iron. Sheep and goat livers must be branded with ink or hot brand.

2. Whole, half, quarter carcasses, and carcasses cut into no more than three pieces must be branded with ink or hot brand. The brands must be applied to the external surface of the thighs, loins, back, breast, and shoulder of each carcass weighing more than 143 lbs. (65 kg) and to the thighs and shoulders on all other carcasses.

DISTRIBUTION: All MPI Offices, T/A Inspectors, Plant Management, T/A Plant Management, Science and Compliance Offices, Import Offices, R&E, TRA,

OPI: International Programs/ECD

3. If cuts of meat, tongues, or meat byproducts (for livers, see 1. above) are bulk packed directly into a shipping carton, or bulk packed into a poly wrapper (liner or bag) for placing into a shipping carton, the official inspection legend must be applied or printed on the shipping carton as described in subparagraph 6. The wrapping is not required to bear the inspection legend.

4. Portions of meat wrapped for direct retail sale must bear a legend on both the wrapping and packaging.

5. Meat products must bear the legend applied:

a. Either to the product or the wrapping of the product.

b. To any packaging thereof.

6. In all cases where the inspection legend has been applied to packaging, or is printed on packaging, it shall have been applied or printed in such a manner so that the legend shall be destroyed when the package is opened, unless the packaging is not capable of being used again as packaging.

B. **Wrapping and Packaging.**

1. A wrapper and wrapping is that material that contacts the meat product.

2. If wrapping material is used, it must be transparent and colorless unless it fulfills all the protective requirements of packaging thereby becoming packaging material.

3. A package or packaging is defined as the outer container of any material into which the meat product is placed. This does not include a bulk container which is part of a road vehicle.

This information should be used in conjunction with the requirements specified in Section 22.39 of the Meat and Poultry Inspection Manual and other notifications pertaining to the United Kingdom.

Deputy Administrator
Meat and Poultry Inspection Operations

UNITED STATES DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
WASHINGTON, D.C.

FSIS DIRECTIVE

9510.1
REVISION 1

4-2-86

INSPECTION PROCEDURES FOR IMPORTED VENISON

I. PURPOSE

This Directive updates the procedures for inspecting imported venison and the manner in which it may be used in domestic products processed in federally inspected establishments.

II. CANCELLATION

FSIS Directive 9510.1, dated 3/13/85.

III. REASON FOR ISSUANCE

To provide agency policy concerning imported venison and its use as an ingredient either in domestic meat products or in an article of food derived from meat, meat byproducts, or meat food products, prepared in federally inspected establishments. Deer is not a regulated species under the Federal Meat Inspection Act (FMIA). Although the Agricultural Marketing Act (AMA) permits voluntary inspection of species not regulated by the FMIA, the authority of the AMA does not extend to imported product. The AMA does permit voluntary inspection of the manufacture of a food article for wholesomeness. Therefore, as long as imported venison can be shown to be safe and wholesome, the Agency will permit its use as an ingredient in properly labeled inspected products which also contain some domestic meat, meat byproducts, or meat food products, as provided in this directive.

IV. REFERENCES

Parts 317, 327, and 350 of the Federal meat inspection regulations, Federal Meat Inspection Act, Agricultural Marketing Act.

V. FORMS AND ABBREVIATIONS

The following will appear in their shortened form in this Directive:

AIIS	Automated Import Information System
IIC	Inspector in Charge

DISTRIBUTION: All MPI Offices, T/A Inspectors, Plant Management, T/A Plant Management, Science and Compliance Offices, Import Offices, R&E, TRA, ABB, ICL

OPI: Foreign Programs/IP

VI. POLICY

A. General. Venison shipped to a U.S. establishment must have been produced in a country that maintains an inspection program in compliance with Part 327 of the Federal meat inspection regulations, specifically including species testing, residue sampling, and boneless deer reinspection.

B. Requests for import inspection.

1. Requests for import inspection of venison may be made by import brokers notifying USDA inspection personnel at the appropriate import office.

2. The import inspection station will then notify headquarters through channels.

C. Import inspection.

1. Import inspection shall be conducted at a facility approved by USDA as complying with the requirements for importation of product into the U.S. under Part 327 of the Federal meat inspection regulations.

2. USDA shall perform import inspection as required by Part 327 of the Federal meat inspection regulations. Specific requirements include the following:

   a. Initial entries and assignments will be drawn through the AIIS system. Use product codes RABWX3 for boneless venison meat and RABXE3 for venison organs.

   b. The inspector shall draw samples for residue-species analysis from each lot of venison and send samples to the laboratory serving that location.

   c. All import inspection documents shall be filed in the import office.

   d. If product fails import inspection, the inspector shall retain the product and notify headquarters through field channels.

   e. Foreign inspection certificates accompanying the venison product during shipment must conform with specified requirements. New Zealand is the only country presently eligible to export venison to the U.S. The attached Form Ag.-M.102A with the following additional statement complies with all requirements: "The venison and/or venison food products described herein was/were prepared in plants certified for importation of their products into the United States and are not adulterated or misbranded as defined by the regulations governing meat inspection of the U.S. Department of Agriculture; and that said products have been handled in a sanitary manner in New Zealand and are otherwise in compliance with the requirements at least equal to the Federal Meat Inspection Act and said regulations."

D. **Review of foreign inspection systems.** USDA shall periodically review any approved system and its certified facilities to determine continued eligibility to export venison to U.S. establishments.

+[E. **Conditions of use.** Imported venison may be used in a federally inspected establishment only when conditions 1 and 2 listed below are satisfied.]+

1. +[The imported venison is derived from deer that were slaughtered+] and received ante-mortem and post-mortem inspection in establishments under the supervision of a USDA approved foreign meat inspection system as required by Part 327; and

2. a. It is to be used as an ingredient in an inspected meat product prepared at a USDA establishment, and the product contains more than 3 percent of an uncooked portion (2 percent or more if cooked) of a carcass from a species subject to the Federal Meat Inspection Act (amenable species) or at least 30 percent fat from an amenable species, or

b. It is to be used as an ingredient in a manufactured food article containing USDA inspected domestic meat, meat byproducts, or meat food products and the food article is not subject to Federal meat inspection laws and is voluntarily inspected for the purpose of obtaining the Federal mark of inspection under Part 350 of the regulations; there is no minimum amount of meat, meat byproduct, or meat food product required in the article except that these materials must have been derived from federally inspected and passed carcasses.

F. **Labels.** The domestic establishment designated to receive the imported venison must have obtained USDA approval of labels to be used on product containing the imported venison under section 317.4 of the Federal meat inspection regulations.

G. **Inspection fees.**

1. All charges for import inspection and reviews of foreign certified facilities shall be billed to the importer at the current rate for voluntary inspection as specified in section 350.7 of the Federal meat and poultry inspection regulations.

2. Inspection of product produced in the U.S. establishment shall be charged to the establishment operator if such product is produced under the voluntary food inspection service provisions of section 350.3 of the regulations. Otherwise, inplant inspection is mandatory and thus is conducted at no charge.

H. **Approved foreign establishments.** The following establishments are presently authorized to ship venison to U.S. establishments:

+[(No. PH-131) +]
Summit Deer Products, Ltd.
Kaimai Summit
R.D. 1
Tauranga, New Zealand

No. DSP-6 (No. PH-15)
NZ Primary Processors Ltd.
CNR Mark Road and Triton Ave.
P.O. Box 4214
Mt. Maunganui, New Zealand

+[I. **Noninspected venison.** Imported venison that was not inspected by USDA under the provisions of this Directive may be stored in an official establishment only if it is:

1. Completely enclosed in properly identified containers,

2. Recorded on a current inventory showing amounts received and shipped, and

3. Stored in a single area separated from inspected product.]+

Administrator

Attachment
Ag.-M. 102A, Official Inspection
Certificate for Slaughtered Farmed Deer

Ag.-M. 102A

NEW ZEALAND GOVERNMENT
MINISTRY OF AGRICULTURE
AND FISHERIES

OFFICIAL INSPECTION CERTIFICATE FOR SLAUGHTERED FARMED DEER

I HEREBY CERTIFY that:

(i) The venison and/or venison food products described herein was/were derived from animals subjected to ante- and post-mortem veterinary inspection at the time of slaughter and found to be free from disease and suitable in every way for human consumption and that it/they has/have not been treated with chemical preservatives or other foreign substances injurious to health.

(ii) The game was inspected and processed pursuant to the New Zealand Game Regulations 1975 in establishments licensed under those regulations.

(iii) Foot and mouth disease, rinderpest or swine fever do not occur in New Zealand.

(iv) The venison and/or venison food products was/were derived from animals of New Zealand origin.

Consignor	
Consignee	
Ship or flight No.	Port of loading
Port of discharge	Final destination (if on carriage)

Marks and brands:	Number and kind of packages:	Description of goods	Net weight (state unit)

ORIGINAL

Order Nos.	Processed at:
Species	Slaughtered at:

....
v Zealand Government

UNITED STATES DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
WASHINGTON, D.C.

CHANGE TRANSMITTAL SHEET

☒ DIRECTIVE
☐ REVISION
☒ AMENDMENT
☐ OTHER

FSIS DIRECTIVE
Use of Disposable Shipping Containers

10,140.1
Amend. 1

3-6-86

I. PRINCIPAL CHANGES

Paragraph V. amended to change form color designations for the Kentucky State Laboratory and Western Laboratory from salmon and orange to purple and warm red respectively.

II. FILING INSTRUCTIONS

Remove Old Page	Insert New Page
1	1

III. CANCELLATION

This transmittal is cancelled when contents have been incorporated into FSIS Directive 10,140.1.

Administrator

Attachment

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OPI: Science Program

UNITED STATES DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
WASHINGTON, D.C.

FSIS DIRECTIVE

10,140.1
Amend. 1

3-6-86

USE OF DISPOSABLE SHIPPING CONTAINERS

I. PURPOSE

This directive prescribes the use and procedures for obtaining supplies of disposable shipping containers. The one-way disposable shipping container is intended primarily for use by plant inspectors to mail food chemistry samples which do not require insulation or other special handling.

II. (RESERVED)

III. (RESERVED)

IV. REFERENCES

Section 23.5, Meat and Poultry Inspection Manual; most current FSIS Notice on "Change of Destination Laboratories for Certain Samples."

V. FORMS AND ABBREVIATIONS

The following will appear as abbreviated or otherwise referred to in this directive.

ASD	Administrative Services Division
DSC	Disposable Shipping Container
PSB	Program Services Branch, ASD
MPIO	Meat and Poultry Inspection Operations
RO	Regional Office

MP Forms 128 through 128-6, color-coded, preaddressed, pressure sensitive mailing labels:

MP Form 128	Eastern Laboratory	(green)
MP Form 128-1	Webb Foodlab, Inc	(blue)
MP Form 128-2	Midwestern Laboratory	(red)
MP Form 128-3	Kentucky State Laboratory	(purple)
MP Form 128-4	Western Laboratory	(warm red)

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OPI: Science Program

UNITED STATES DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
WASHINGTON, D.C.

FSIS DIRECTIVE

10,610.1 | 3-10-86

PROCEDURES FOR EMERGENCY RESPONSE SAMPLES

I. PURPOSE

This Directive establishes procedures to be followed by Science Laboratories when processing Emergency Response Samples. Such samples may include, but are not limited to, samples originating from Emergency Programs Staff, Epidemiology Branch (consumer complaints), Compliance Division, Office of the Inspector General, Food and Drug Administration, special samples submitted by FSIS field personnel, and samples of high priority submitted by other oganizations.

II. (RESERVED)

III. (RESERVED)

IV. REFERENCES

FSIS Directives 8080.1, 8150.1, 8410.1, 10,130.1, 10,600.1, 10,600.2, 10,620.1; Meat and Poultry Inspection Manual, Part 23A; Science, Microbiology Division, Policy for Response to Microbiological Incident.

V. FORMS AND ABBREVIATIONS

The following will appear as abbreviated in this directive.

AOAC	Association of Official Analytical Chemists
QA	Quality Assurance
QC	Quality Control
FSLD	Field Service Laboratories Division

VI. POLICY

A. It is the policy of FSIS laboratories to expedite handling and processing of all samples received for response to an emergency situation. Samples identified as high priority, emergency response shall be processed in a manner that provides for:

1. Maintenance of sample integrity and identity;
2. Rapid and accurate coordination of information;
3. Rapid identification of the potential problem;

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OPI: Science, Field Service Laboratories Division

4. Accurate, rapid analysis of the sample;
5. Rapid reporting of analytical results;
6. Maintenance of reserve sample for reanalysis or evidence.

B. These objectives can be accomplished by:

1. Identifying and resolving associated problems (e.g., analytical, QA/QC, resource or handling).
2. Coordinating and communicating information rapidly and accurately.
3. Transferring the sample to qualified staff with the equipment and supplies necessary to complete the analysis.
4. Rapidly and accurately analyzing the sample.
5. Ensuring that results are properly reported.

VII. DEFINITIONS

A. **Laboratory**. This includes three Field Service Laboratories (Athens, GA.; St. Louis, MO; and Alameda, CA).

B. **Laboratory Director**. This includes the Directors of the three Field Service Laboratories.

C. **Responsible Supervisor**. This includes the In-Charges and First Line Supervisors in the Field Service Laboratories.

D. **Responsible Analyst**. This is the lead analyst to whom the sample is assigned.

VIII. RESPONSIBILITIES

A. Emergency Programs Staff And Science Program Headquarters.

1. **Coordination**. The Emergency Programs Staff will coordinate all responses to emergency situations. When initial information is obtained, they will determine the general problem, background information, potential impact, and what analyses should be considered. They will then meet with the Science technical staffs to determine disciplines involved, information requirements and the number of samples necessary to resolve the problem. They will provide situation summary fact sheets, updates, and case close outs directly to the affected laboratory(ies) and Headquarters staff.

2. **Laboratory Designation and Sample Shipment**. The Director, FSLD, in consultation with the Laboratory Director(s), will determine which laboratory(ies) will respond. Using this information, the Emergency Programs Staff will arrange sample shipment to the designated Laboratory(ies).

3. **Communicating and Reporting Situation Information**. Emergency Programs Staff, Compliance Division, Epidemiology Branch, or the FSIS Information Staff will coordinate, communicate and report situation information outside the Science Program.

B. **Laboratory.**

1. **Notification of Agency Staff.** If alerted to an emergency response situation by other than Science Program staff, Laboratory Directors should notify the Director, FSLD, who will notify the Office of the Deputy Administrator, Science, and other appropriate staffs.

2. **Requesting Information From the Site.**

a. If routine information is required, the Responsible Supervisor or Responsible Analyst should request it from the Director, FSLD, or contact the site (establishment) directly after notifying the Regional Office.

b. If non-routine information or guidance is required from the site, request it from Emergency Programs Staff through the Director, FSLD.

3. **Information From/To Non-Agency Staff.** If conditions warrant, the Responsible Supervisor may contact field level staff at the Environmental Protection Agency, Food and Drug Administration, and other appropriate Federal or non-Federal organizations for technological assistance. Situation information should not be released (as part of these queries) unless authorized by the Office of the Deputy Administrator, Science, Emergency Programs staff, or a designated spokesperson.

4. **Assessment of Staff Equipment and Supply Requirements.** The responsible supervisor will estimate the staff, equipment, and supplies necessary to perform the analyses. If staff, equipment or supplies are needed from another organization, request them through established channels.

5. **Maintenance of a Log.** The laboratory will maintain a bound log(s) to record key conversations associated with each incident. Each record will identify the parties involved, their titles, organizations, phone numbers, conversation summaries, and the dates and times of the occurences.

6. **Identification of the Sample As Emergency Response.** Upon receipt of an Emergency Response Sample, follow appropriate Laboratory procedures for identification and control.

7. **Initial Communication with Agency Staff.**

a. Upon sample receipt, the Laboratory Director should immediately notify the Director, FSLD, who will alert other appropriate staffs.

b. The Laboratory Director will ensure that the Responsible Supervisor or Responsible Analyst obtains information on the nature of the situation to be evaluated, available methods, and health risks associated with the emergency response situation from appropriate Agency staff.

8. **Methodology**. If available, always use official methods. If an approved method does not exist, adapt an existing method or develop an alternative method with the technical guidance of the appropriate headquarters staff (e.g., Chemistry Division).

9. **Validity Profile Acceptance Criteria**.

a. For chemical analyses, develop and implement a QA/QC plan as follows:

(1) If using an official (AOAC or FSIS validated) method, apply existing QA requirements.

(2) If using an unofficial quantitative chemical method, develop a validity profile in accordance with FSIS Directive 10,130.1.

b. For microbiology analyses, use QA/QC guidelines contained in the appropriate "Laboratory Communication(s)".

c. For pathology analyses, develop an appropriate validity profile using applicable controls.

d. If the urgency of the situation precludes this work, the validity profile acceptance criteria for each discipline may be modified with the concurrence of the appropriate Science Division Director.

10. **Reporting Analytical Findings**.

a. Prior to reporting the analytical findings, the Responsible Supervisor and Responsible Analyst will:

(1) Verify the receipt of forms and reports; and,

(2) Review the analytical findings.

Questionable results will be evaluated by the appropriate Science Division Director prior to official reporting.

b. Findings will be reported expeditiously to the Responsible Supervisor. Other program offices will obtain results through the Director, FSLD. The laboratory will follow special reporting instructions annotated on the FSIS Sample Control form as well as telecopy the results to FSLD.

c. For each Microbiology, Chemistry, and Pathology Section, detailed analytical records (including QA/QC analyses) as well as facsimiles of appropriate log book entries will be secured in locked file cabinet(s). These records will be maintained for at least 3 years, prior to storage in the Agency's archives.

Administrator

UNITED STATES DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
WASHINGTON, D.C.

CHANGE TRANSMITTAL SHEET

☒ DIRECTIVE
☐ REVISION
☐ AMENDMENT
☒ OTHER

FSIS DIRECTIVE
SANITATION HANDBOOK FOR MEAT AND POULTRY INSPECTORS
11,000.1
3-21-86

I. PURPOSE

This document transmits the cover page to FSIS Directive 11,000.1, Sanitation Handbook for Meat and Poultry Inspectors, which you should currently have on file. This action simply classifies the Sanitation Handbook as a directive, and therefore permits it to be indexed, updated and made available through the Agency's directives system. Also transmitted are revised pages to the Sanitation Handbook itself.

II. INSTRUCTIONS

A. Remove the current pages of the Handbook and insert the revised pages provided herein in numerical order.

B. Attach the FSIS Directive 11,000.1 cover sheet to the Handbook and maintain in appropriate order with FSIS directives.

III. CANCELLATIONS

A. MPI Bulletin 83-23 is cancelled.

B. This change transmittal is cancelled when instructions have been accomplished.

James F. Payne
Deputy Administrator (for)
Meat and Poultry Inspection Operations

Attachment
FSIS Directive 11,000.1

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OPI: MPITS/Facilities, Equipment and Sanitation Division

UNITED STATES DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
WASHINGTON, D.C.

FSIS DIRECTIVE

11,000.1 | 3-21-86

SANITATION HANDBOOK FOR MEAT AND POULTRY INSPECTORS

I. PURPOSE

This directive provides the Sanitation Handbook for Meat and Poultry Inspectors (Attachment).

II. RESERVED

III. RESERVED

IV. REFERENCES

Meat and Poultry Inspection Regulations, Parts 308 and 381, subpart H.

V. POLICY

The attached Sanitation Handbook is to be used as a guideline and in conjunction with applicable regulations by FSIS inspectors concerned with sanitation in meat and poultry establishments.

James K Payne

Deputy Administrator (for)
Meat and Poultry Inspection Operations

Attachment
  Sanitation Handbook for
  Meat and Poultry Inspectors

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CHAPTER 3

SANITATION INSPECTION

1.0 Introduction

1.1 Sanitation is everybody's job and is not limited to those who have departmental or plant responsibility. All inspectors whose work involves plant assignments are sanitation inspectors. All inspectors on duty are responsible for sanitation inspection while operations are in progress.

1.2 It is also the duty of each inspector to keep the supervisor informed. It is very advantageous for the supervisor to have advance information when a plant protest or complaint is likely to occur. This will enable the inspector and supervisor to work as a team.

1.3 The supervisor should be contacted when there are areas of doubt or problems with which the inspector may need assistance. The supervisor is also interested in problems that may have significance in other departments or plants, as well as situations where the inspector has achieved unusually good results.

2.0 Pre-operations Inspection

2.1 When the MPI inspector arrives for his pre-operations sanitation inspection, the job is to determine if the plant has fulfilled its responsibility.

2.2 To conduct pre-operations sanitation inspection, the inspector needs to be equipped with a good flashlight, and pencil, U.S. Retained and U.S. Reject tags, string, a clean cloth or paper towel, and a pocket knife, spatula or similar probe or scraping instrument.

2.3 Since the inspector cannot examine everything each day, the available time must be spent trying to determine the overall acceptability of clean up by looking at key spots, such as product-contact zones and difficult-to-clean areas. The inspector should examine machinery or areas most likely to be poorly cleaned. Dismantled equipment and pipelines should not be assembled for use before a specified time to assure an opportunity for inspection.

2.4 Pre-operations sanitation inspection affords one of the few opportunities to observe the inner surfaces of dismantled equipment and to make an overall judgment as to the effectiveness of the plant's clean-up operations.

2.5 The inspector's time is very valuable and should not be wasted in inspecting large numbers of one item such as buckets, pans, trucks, etc. A representative number of individual pieces should be carefully examined, and the determination to accept or reject all such items should be made on that basis.

2.6 Segregation of the clean from the dirty is the establishment's--not the inspector's--responsibility.

2.7 The inspector should plan his overall schedule and avoid the haphazard approach. Also, the inspector's effectiveness can be increased by avoiding set patterns and definite time schedules.

3.0 Operational Inspection

3.1 Basically, operational sanitation inspection consists of three general areas:

3.1.1 Product handling which includes such items as sanitary dressing procedure, equipment disinfection, handwashing, etc.

3.1.2 Housekeeping sanitation such as floor cleaning, trash removal, control of smoking and spitting, prevention of unnecessary accumulation of bones and scraps, etc.

3.1.3 Detection of potential problems that will need attention before the next operations begin or be programmed for cleaning, repair, maintenance or replacement.

4.0 Inspection Priorities

4.1 The chief concern of sanitation is the protection of product from contamination; therefore, to set up priorities one must give the product primary consideration. Based on the relative importance of different types of contamination, the inspector must establish priorities.

4.2 The following categories are given as general guidelines which should be helpful to all who are concerned with the production of clean product:

4.2.1 Direct Product Contamination

4.2.1.1 This is the most critical category and represents any situation that results in direct contamination of product. These situations require immediate and effective correction. In inspecting equipment, the most critical surfaces are those that routinely contact product, directly or indirectly, during the normal course of operation (i.e., hand tools, knives, saws, cutting boards, table tops, inside surfaces of trucks, choppers, grinders, and other equipment, workers hands, surfaces handled by workers who alternately handle product, etc.)

4.2.1.2 These areas must be absolutely clean before operations involving their use begin. "Clean" in this instance is defined as free from all foreign material such as meat scraps, fat, rust, dust, blood, manure, lubricating grease, cleaning compounds, scale, etc. It must **look clean**, **feel clean** and **smell clean**. Although no microbiological standards have been established by FSIS for equipment surfaces directly contacting product, these surfaces should be cleaned by procedures designed to reduce to a minimum or eliminate bacterial contamination. As a guideline, less than 30 bacteria per square inch are expected on a hard, nonporous surface immediately after it is thoroughly cleaned and sanitized. Most samples will show no growth. The guideline is based on the careful application of the swab/dilution technique. The index for other techniques may vary. The presence of any visible debris can reasonably be assumed to be evidence that thorough cleaning did not occur.

4.2.2 Possible Product Contamination

4.2.2.1 Included in this category are areas or surfaces which have a reasonable possibility of product contact through the course of normal operations. Some examples include certain doorways and posts; smoketrees; workers clothing; outside surfaces of buckets, trucks and other equipment; rail switch pulls, etc.

4.2.2.2 These areas must meet the same standards of cleanliness outlined above, but are usually considered secondary to those in category A. Some of these items can be corrected while production is in progress.

4.2.3 Potential Product Contamination

4.2.3.1 These are areas or surfaces that could potentially contact product directly or indirectly, usually through accidental happenings. Some examples include floors, certain walls, rails, underside of trucks, tables, platforms, etc. Usually these are the areas that can be pointed out and cleaned before the next day's operations and programmed for periodic maintenance and cleaning.

4.2.4 Remote Product Contamination

4.2.4.1 These are areas or surfaces very unlikely to constitute a direct hazard to product but nonetheless must be cleaned (i.e., wall behind a large piece of equipment, etc.). They can cause secondary sanitation problems by attracting and harboring insects or by promoting the growth of microbes that cause odors and that may spread to the product zone in air currents, on personnel and on fomites. These problems can and should be corrected through a long range sanitation program of established periodic cleaning and maintenance (i.e., stuffer piston pulling, vacuum line cleaning, window cleaning, rail cleaning, etc.).

4.2.4.2 These divisions are very relative and it is difficult to make absolute categories as the degree of uncleanliness is very important. A grossly dirty item in the last category could become the first category in importance.

4.2.4.3 For example, a rail can become so dirty and rusty as to be a source of direct product contamination, but it must be remembered it didn't get that way overnight and should have been detected as a potential problem and corrected through the long or medium ranged cleaning and maintenance programs.

4.2.4.4 Rails as well as any other area in the plant must be scheduled for maintenance and cleaning as often as necessary to provide adequate product protection, whether this be on a daily, weekly, monthly or other routine basis.

4.2.4.5 A good job in sanitation eliminates all sources of direct product contamination and most, if not all, sources of possible contamination. Daily, weekly, or other periodic cleaning should be programmed for potential sources of contamination. Sources of remote contamination should be programmed for correction on a long-term basis.

4.2.4.6 Since the inspector cannot observe the operations all the time, he must develop some means of being assured that good sanitation occurs when he is absent as well as when he is present.

4.2.4.7 Good sanitation is no accident. It must be planned and become an integral part of the plant's operation.

CHAPTER 7

OUTSIDE PREMISES

1.0 Location of a plant and the sanitation of its outside premises can have a significant effect on the sanitation inside the plant. Meat and poultry products in the plant, may become exposed to the outside elements through loading docks, doorways, open windows and the passage of workers and visitors in and out of the plant.

2.0 The first step in avoiding contamination is to locate slaughtering and processing plants in areas reasonably free of objectionable odors, such as smoke, flying ash, and dust, originating from such sources as refineries, city dumps, chemical plants, sewage disposal plants, dye works and paper pulp mills. All roadways and railroad sidings servicing the plant should be paved or otherwise rendered dustproof.

3.0 The public as well as visitors and workers commonly pre-judge the inside of a plant by its exterior appearance. This often neglected area of plant sanitation is an important reason for the poor public image of the packing industry. If for no other reason, public opinion should be sufficient justification for maintaining tidy, unlittered, uncluttered, and clean premises. The image of the packing plant as a food processing establishment certainly is not enhanced if the outsider sees it as a junk yard or public dump. It is difficult to relate such surroundings with modern standards of sanitary production and preparation of food. Also, plant workers will be more prone to follow sound sanitary practices in handling product if they work in a clean environment.

4.0 There are some real and potential sanitation hazards as a direct result of poor housekeeping practices on the outside premises. A disorderly, haphazard accumulation of useless materials--such as rusty truck bodies, scrap metal and lumber, and discarded equipment--makes an adequate clean-up of ground surfaces impossible. This produces a ready-made refuge and breeding place for flies, rats and other vermin in addition to trash and dirt being blown about the shipping areas by the wind. The best extermination program cannot be effective, when a ready supply of vermin awaits just outside the plant doors.

5.0 Sanitary maintenance of the outside premises is best handled on a long-range continuing program. Suitable containers or facilities must be provided for routine accumulations of scrap materials and discarded equipment items. An appropriate routine removal of the useless material is essential.

6.0 Storage of useful materials and equipment must be in an orderly manner on elevated racks at least 12 inches high. This is necessary to permit the routine clean-up of waste and debris from all ground surfaces. Plant management must instruct maintenance and repair personnel to promptly and properly store useful items in the provided facilities and not permit the utilization of temporary accumulation points. These "temporary" storage areas have a way of growing and becoming permanent.

7.0 A good program of grounds maintenance must be established whereby all outside premises are raked and policed periodically and weeds kept under control. Weekly intervals are usually adequate.

8.0 Outside burning of plant refuse, such as paper towels, cartons, labeling materials and office waste, frequently can be a sanitation problem. In addition to being a fire hazard, ash, smoke, and partially burned paper may be carried by the wind around the docks, and into the plant if proper incineration facilities are not provided.

9.0 Indiscriminate, ground surface burning of refuse is unacceptable and must not be permitted. If local incineration is desired by plant management, acceptable facilities must be provided which insure positive control of refuse materials, smoke, and flying ash. Unless such approved facilities are present, arrangements must be made for removal of plant refuse on a daily basis or more often if necessary to prevent a nuisance.

CHAPTER 8

PLANT CONSTRUCTION

1.0 Introduction

1.1 Applicants seeking Federal meat inspection must submit for review and approval blueprints or drawings, with specifications, that fully and clearly illustrate the plant as it exists or as proposed to be modified or constructed and equipped for inspection. This approval by the Facilities Staff, FESD, FSIS is necessary prior to granting inspection to determine their adequacy for operating under Federal inspection. When changes are proposed in establishments already under inspection, a similiar process must be followed.

1.2 The primary aim in reviewing the drawings and actual facilities is to determine whether the plant operations can be conducted in a sanitary manner. The plans must also provide for the logical, orderly handling and flow of product. The plant buildings and structures must be of a suitable size and construction for their intended purpose to facilitate maintenance and operation. They must provide sufficient space for orderly placement of equipment and storage of material used in any of the operations. They should also provide separation by partition or by location so as to separate those operations which may cause cross-contamination of food products with bacteria, molds, toxic chemicals, filth, or other extraneous and deleterious materials.

1.3 Floors, walls, and ceilings in the plant should be constructed to be easy to clean and should be kept clean and in good repair. Fixtures, ducts and pipes should not be suspended over working areas where drip or condensate may contaminate foods, raw materials, label and packaging materials or equipment.

2.0 Building Materials

2.1 The building materials listed in this handbook represent the United States Department of Agriculture's minimum requirements. Some variations are acceptable, provided the substitutions are equal or exceed the minimum standards. Materials used shall be easy to clean, impervious and resistant to wear and corrosion. Materials that are absorbent and difficult to keep clean (wood, plasterboard, and porous acoustical-type boards, etc.) are generally unacceptable in departments processing food products.

3.0 Floors

3.1 Floors should be constructed of:

3.1.1 Vitrified brick of good quality, bonded with acid-resistant waterproof mortar, and laid on a waterproof concrete base,

3.1.2 Dense, acid-resistant waterproof concrete, or

3.1.3 Other approved impervious material.

3.2 To prevent accidents, excessively smooth floors should be avoided. Floors where operations are conducted should have a nonslip surface. Good results are obtained by using brick or concrete floors with embedded abrasive particles in the surface.

3.3 Concrete or mortar floors that incorporate an approved latex or synthetic resin base also have better than ordinary resistance to meat fats and acids.

3.4 Floors must be installed and maintained to eliminate all cracks, depressions or other low areas that would accumulate moisture. They should also be properly pitched for efficient drainage. (Specific requirements for floor pitch and drainage are covered elsewhere in this handbook).

4.0 Interior Walls

4.1 Interior walls should be smooth, flat and constructed of impervious materials such as glazed brick, glazed tile, smooth-surfaced portland cement plaster or other FSIS approved nontoxic, nonabsorbent material applied to a suitable base. Glass blocks used in wall panels must have smooth exposed surfaces and be installed so as to prevent breakage by equipment or carcasses. Suitable sanitary type bumpers should be provided on walls to prevent damage by handtrucks, carcass shanks, and the like.

4.2 Window ledges should be sloped about 45° to promote sanitation. To avoid damage to glass in windows the window sills should be 3 feet or more above the floor.

4.3 Coves with radii sufficient to promote sanitary practices should be installed at the juncture of floors and walls in all rooms.

5.0 Doorways and Doors

5.1 Doorways should be wide enough to permit product transferred on rails or in handtrucks to pass through without contacting the jambs. A width of five feet is recommended except that 4½ feet is acceptable when used in connection with 11 foot rails.

5.2 If frequently contacted by product, doors and door jambs should be clad with rust-resistant metal with tight soldered or welded seams.

5.3 The juncture of the door jambs and the walls should be effectively sealed with a flexible sealing compound.

6.0 Ceilings

6.1 Ceilings should be of good height such as 10 feet or more in workrooms.

6.2 Ceilings can be an important source of direct product contamination. Therefore, they must be maintained free of scaling paint or plaster, dust, condensate and leaks at all times. If possible, it is best to avoid painting ceiling surfaces.

6.3 Unnecessary overhead structures such as wiring, pipes and hangers not in use, should be removed as they constitute a needless source of potential contamination. A routine cleaning of overhead structures is essential.

6.4 So far as structural conditions permit, ceilings shall be smooth and flat. They should be constructed of portland cement plaster, large-size cement asbestos boards with joints sealed with a flexible sealing compound, or other acceptable impervious material. If the ceiling has exposed joists, the joists must be at least 36 inches on center and designed so that there are no excessive ledges or crevices which would be difficult to keep clean.

7.0 Interior Woodwork

7.1 In those situations where the use of exposed interior woodwork is unavoidable, dressed lumber should be used. The exposed wood surfaces should be painted with either a good grade nontoxic oil or plastic base paint, or treated with hot linseed oil or a clear wood sealer. The latter two treatments are preferred, particularly on ceiling areas.

8.0 Stairs

8.1 Stairs in departments handling edible product should be of impervious construction with solid treads and closed risers. They should also have side curbs of similar material, measuring 6 inches high at the front edge of the trends.

9.0 Screens, Insect Control, and Rodent Proofing

9.1 The plant and facilities must provide adequate screening and other protection to exclude birds, dogs, cats, and vermin (including, but not limited to insects and rodents).

9.2 All windows, doorways, and other openings that would admit insects such as flies shall be equipped with effective insect and rodent screens. Effectively designed and installed "fly chaser" fans and ducts should be provided over doorways in outside walls of food handling areas that are used for shipping or receiving. Processing rooms should not open directly to the outside of the building for shipping and receiving operations.

9.3 Except in the case of solid masonary walls constructed of glazed tile, glazed brick, etc., expanded metal or wire not exceeding ½ inch mesh should be imbedded in walls and floors at their junction. This mesh should extend vertically and horizontally a sufficient distance to exclude the entrance of rats and other rodents.

CHAPTER 10

PLANT VENTILATION

1.0 Adequate and properly designed ventilating facilities and equipment are closely related to good plant sanitation. Objectionable vapors and odors must be promptly removed so they are not absorbed by exposed product. Also such vapors, including steam, can seriously reduce visibility and otherwise hamper comfort and safety in the workroom.

2.0 Therefore, it is important that adequate means for ventilation be provided in all workrooms and welfare rooms. This may be accomplished by means of ventilating-type windows, skylights, or both; or by mechanical means such as air conditioning or a fan-and-duct system. Windows should be the fixed type in locations subject to dust and objectionable odors, such as those adjoining livestock pens, runways, and inedible departments.

3.0 A reasonable amount of mechanical ventilation with fresh air must be continuously supplied to prevent stagnation of air in refrigerated workrooms where natural ventilation is limted and where a considerable number of operatives are continuously employed, as in large cutting and boning rooms and bacon-slicing rooms.

4.0 Fresh air intakes for workrooms and welfare rooms should be so located that air is not contaminated with odors, dust, smoke, etc. The intakes must be provided with effective filters to eliminate insects, dust, etc. A heating element for tempering the air in cold weather should be provided when needed. Mechanical ventilating systems with the capacity to produce at least six complete air changes hourly should be provided for nonrefrigerated work areas and welfare rooms that depend entirely on artificial means of ventilation.

CHAPTER 15

PLANT WASTE DISPOSAL

1.0 The control and disposal of waste are a major concern. Optimum utilization and reduction of waste are an essential goal of economic production in all plants.

2.0 In slaughter and processing plants there often are enormous quantities of waste which must be disposed of in a suitable manner. Protection of the nation's limited water resources is mutually beneficial to industry, special groups, individual citizens, and the nation as a whole. In recognition of this fact, industries, government agencies and communities are paying increasing attention to the disposal of waste in a manner which will not impair the utility of Public streams and waterways for other beneficial uses.

3.0 From a plant sanitation standpoint, waste disposal has two concerns of vital importance.

3.1 Plant waste represents most of the contaminants, filth, and disease producing organisms that the sanitation program has eliminated from actual or potential contact with edible product. It is essential that this material be kept separate and be disposed of in a manner that does not pose a further threat to edible product or human health.

3.2 Plant waste by their very nature have a high nuisance potential. The foul odor and attractiveness to insects and rodents should be obvious justification for sanitary, efficient and safe disposal of waste.

4.0 There are four general categories of plant waste considered here: a. Sewage disposal from both the sanitary and plant drainage lines, b. Grease recovery, c. Disposal of organic waste such as paunch contents, hog hair, blood, manure, etc., and d. Rubbish removal.

4.1 Sewage Disposal

4.1.1 The sewage disposal facilities utilized by the plant must be acceptable to the local authorities having jurisdiction over such matters in the area. A letter from the proper authorities is to be on file with the Inspector in Charge for each plant under inspection.

4.1.2 The most desirable situation is for the plant sewage to discharge into a municipal sewer system. Due to the frequently enormous amounts of sewage from some plants, this may constitute an undue burden on the municipal system and the plant must make other arrangements with local authorities. In some municipalities as much as 50 to 75 percent of the sewage entering its disposal plant is from slaughter plant operations.

4.1.3 If a private septic tank or sewage disposal system is used, it must be efficiently designed and operated so as not to produce objectionable conditions on or near the official premises.

4.1.4 It is highly undesirable and unlikely that any untreated sewage from the sanitary lines (toilets and urinals) would be allowed by local authorities to discharge into a stream. However, such disposal of some liquid wastes from the plant drainage may be permitted. In this case, the flow of water must be sufficient at all seasons of the year to carry the sewage well away from the plant.

4.2 Catch Basins and Grease Traps for Grease Recovery

4.2.1 Liquid waste from meat plants usually contain large amounts of fat. Reclamation of this fat has certain economic advantages in addition to being a form of preliminary sewage treatment.

4.2.2 Sanitary drainage lines (from toilets and urinals) must not discharge into a catch basin or grease trap, but may join with the effluents of these areas to constitute the total sewage of the plant.

4.2.3 Catch basins are large tanks which receive the plant drainage and allow it to slow down in its flow so that grease and other material may float to the top and be skimmed off and taken to the inedible rendering department (or in some cases, to an outside renderer). Some solid materials settle to the bottom and must be removed periodically during the day to prevent their decomposition or otherwise creating an objectionable condition.

4.2.4 Suitable facilities, such as a blow tank or water-tight containers, must be provided for the transfer of grease to the point of disposal after it is skimmed from the basins. Settlings are to be handled in a similar manner.

4.2.5 Catch basins must be suitably located and not placed in or near edible products departments or areas where edible products are unloaded from or loaded onto vehicles. The area surrounding an outside catch basin shall be paved with impervious material such as concrete, and provided with suitable drainage facilities.

4.2.6 To facilitate ready cleaning, basins must have inclined bottoms and should be without covers. They are to be constructed so that they can be completely emptied of their contents for thorough cleaning each day following the plant operation. Hose connections for furnishing hot water for clean-up purposes should be provided at convenient locations near the basins.

CHAPTER 16

EQUIPMENT

1.0 Introduction

1.1 Equipment used in meat and poultry slaughter and processing plants ranges from simple hand tools to large, highly complex electronically-operated machinery. The product contact surfaces of equipment are reviewed for potential hazards to the cleanliness and product safety.

1.2 Formal acceptance of a piece of equipment will not necessarily mean that it can be used without reservation. Poor quality workmanship, inadequate service and maintenance, substitution of materials, faulty installation, or other defects may make an otherwise acceptable machine unacceptable. When such defects can be corrected after installation, the inspector will require correction as a condition for use.

1.3 Otherwise, the equipment will be rejected and the inspector will report the defects to the Equipment Group.

2.0 Equipment Standards

2.1 To be considered acceptable, equipment and utensils must meet certain basic criteria. They must be made of acceptable materials, must be constructed so they can be cleaned and inspected, must be designed for sanitary maintenance, and must not constitute a safety or health hazard to inspectors.

2.2 Acceptable Materials:

2.2.1 Equipment must be constructed of materials capable of preventing deterioration through normal use or deterioration by chemicals, cleaning agents, and atmospheric exposure in the normal production environment. They must be smooth surfaced, corrosion and abrasion resistant, shatterproof, nontoxic, nonabsorbent, and shall not stain or migrate to the product.

2.2.2 **Stainless Steel**: The 18-8 (300 series) is acceptable for general use. There are other series which have been used for construction of meat and poultry equipment, but their use is limited because they tend to rust or discolor in certain applications. The abbreviation "S/S" is used throughout this publication to denote stainless steel construction.

2.2.3 **Aluminum**: May pit or corrode when exposed to certain chemicals. When friction occurs between aluminum and meat or fat, a black oxide is produced which discolors the meat. Anodizing the aluminum does not eliminate this problem. Therefore, the use of aluminum is limited to applications where the metal does not contact the product or in which the product is suspended in water.

2.2.4 **Surface Coatings and Platings**: Are acceptable providing they render the base metal noncorrosive and meet the definition for an acceptable material. Failure of plating materials to remain intact is justification for inspection personnel to require that the use of equipment so affected be discontinued. Such platings as chromium, nickel, tin, and zinc (as galvanized iron) are usually acceptable, depending upon the specific use.

2.2.5 **Plastics and Metal Alloys**: Are acceptable when judged by the Chemistry Staff to be suitable for contacting product and are physically acceptable for their intended use by the Equipment Group.

2.2.6 **Hardwood**: Is acceptable when used as removable cutting boards or as removable racks for dry curing meat. Since wood absorbs moisture, it is unacceptable for any other equipment uses.

2.2.7 **Other Materials**: As new materials are developed and proposed, they will be considered on their merits.

2.3 Unacceptable Materials:

2.3.1 There are many materials that are highly undesirable or totally unacceptable for use in equipment construction. The following is a partial listing. Questions on other materials should be directed to the Equipment Group, FESD, MPI-TS, FSIS.

2.3.2 **Cadmium and Antimony**: Are toxic materials and may not be used in any manner on equipment for handling edible product.

2.3.3 **Lead**: Is a toxic material and may not be used in equipment contacting edible product except that it may be employed in certain alloys in an amount not to exceed 5 percent.

2.3.4 **Enamelware and Porcelain**: Are not acceptable for any purpose in connection with the handling and processing of product.

2.3.5 **Copper, Brass, and Bronze**: Are not acceptable when used in contact with fats and oils, because their use results in objectionable greenish discoloration and decreases keeping quality of fat. They may be used in air and water lines and for gears and bushings outside the product zone.

2.3.6 Leather and fabrics, due to their porous nature, are not acceptable materials for equipment construction. Filter cloths used in rendered fat filter presses are permitted, provided they are clean and freshly laundered.

3.0 Equipment Design and Construction

3.1 Sanitary design prinicīples apply to all types of equipment used in the slaughter of livestock and the handling and processing of product. The primary objective of sanitary design is to facilitate keeping equipment clean, thereby controlling and preferably eliminating product contamination. The continuing push for greater and greater production generally tends to increase the contamination hazards and sometimes seriously curtails the time available for clean-up. Sound sanitary design of both the plant and equipment then becomes even more essential.

3.2 In order to encourage the thorough cleaning of equipment, the time and the ease of disassembly are important considerations. Equipment should be as simple in construction as possible and contain the fewest number of parts practical to permit easy dismantling and reassembly following cleaning. The design, construction, and installation should be such that permits easy access for sanitary, as well as mechanical, maintenance.

3.3 Equipment shall be designed and constructed in such a manner that it can be readily cleaned.

3.3.1 All product contact surfaces shall be readily accessible for cleaning and inspecting and constructed of corrosion resistant materials.

3.3.2 All surfaces contacting product shall be smooth, free from pits, crevices, and scale and shall be capable of being so maintained.

3.3.3 All parts of the product zone shall be free of recesses, open seams, gaps, protruding ledges, inside threads, inside shoulders, bolts, rivets, and dead ends. In large equipment, appropriately located clean-out and inspection openings, catwalks, ladders, or other suitable provisions must be made to insure that all parts can be cleaned and inspected. It is the plant management's responsibility to demonstrate compliance with this requirement.

3.3.4 Bearings shall be located outside the product zone and the construction of these shall be such that lubricant cannot leak, drip, or be forced into the product zone. A removable seal assembly must be provided at the entrance of the product zone for easy cleaning and inspection.

3.3.5 Internal corners or angles in the product zone shall have a continuous and smooth radius of one-fourth inch or greater except that lesser radii may be used where necessary for proper functioning of parts or to facilitate drainage, provided such areas can be readily cleaned.

3.3.6 Equipment shall be self-draining or otherwise completely evacuated.

3.3.7 Horizontal ledges or frame members shall be held to a minimum outside the product zone and shall be of rounded or tubular construction, where possible, to prevent accumulation of debris and promote sanitation.

3.3.8 Equipment shall be so designed, constructed, and installed as to guard against injury to personnel from sharp edges, moving parts, electrical shocks, excessive noise, and other hazards. Safety or gear guards shall be removable to permit inspecting and cleaning.

3.3.9 All welding shall be continuous, smooth, even, and relatively flush with the adjacent surfaces.

3.3.10 Painted surfaces of equipment or components in or above the product zone are not acceptable.

3.3.11 All external surfaces that do not contact food product shall be free of open seams, gaps, crevices, and inaccessible recesses.

3.3.12 Where parts must be retained by nuts or bolts, fixed studs with wing nuts should be used rather than screws to a tapped hole.

3.3.13 Electric motors and other electric gear should be sealed or otherwise protected to prevent entry of water and product.

3.3.14 All gasketing and packing material shall be nontoxic, nonporous, nonabsorbent, and unaffected by food products and cleaning compounds.

3.4 Clean-in-Place (CIP) System

3.4.1 Sanitation procedures for CIP systems must be as effective as those for cleaning and sanitizing disassembled equipment. To remove all organic and inorganic residues, CIP system must meet the following criteria:

3.4.2 Cleaning and sanitizing solutions and rinse water must contact all interior surfaces of the system.

3.4.3 The system must be self-draining with no low or sagging areas.

3.4.4 Pipe interiors must be highly polished (120-180 grit) stainless steel for easy inspection.

3.4.5 Install easily removable elbows at each change of direction to provide access for inspection.

3.4.6 Any part not included in CIP system must be provided with removable elbows at each change of direction and be dismantled and manually cleaned.

3.4.7 All sections of the system, including overhead lines, must be available for inspection without safety hazard to inspectors.

3.4.8 Effectiveness of CIP system must be evaluated by periodic dismantling for inspection of its interior surfaces.

3.5 Screens, Strainers, and Filters

3.5.1 Such devices shall be readily removable for cleaning and inspecting and shall be designed to prevent wrong installation. Permanent screening and straining surfaces should be of rust-resistant metal. Filter paper shall be of single-service type. Filter cloths shall be washable.

3.6 Pumps and Pipelines

3.6.1 Pumps, pipes, conductors, valves, and fittings, used in connection with edible product (including pickle or vinegar solutions), should be of 300 Series stainless steel or approved plastic. High impact resistant glass pipelines may be approved on an individual basis by MPITS, FESD.

3.6.2 Pumps and pipelines conveying product must be easy to dismantle for cleaning and must not have dead space where product may stagnate. Sanitary-quick disconnects shall be installed at all changes of direction by the use of easily removable elbows to provide an access for cleaning and inspection of pipelines. These requirements apply to lines used to convey raw fat and to recirculate rendered fats used in cooking and frying operations. Black iron pipelines with threaded or welded joints are acceptable for conveying rendered fats. Continuous rendering is not considered complete until after the final centrifuge.

3.7 Conveyor Belts

3.7.1 All belts used to convey exposed product must be of sanitary grade, moisture-resistant, nonabsorbent material with no exposed fabric core.

3.7.2 Composition belts must have the edges sealed with the same material as is used on the food contact surface. All belts are evaluated and accepted by the Equipment Group, FESD, MPI-TS, FSIS.

3.7.3 Conveyor guides, splash guards, etc., shall be easily removed to permit cleaning, inspection.

3.8 Smokehouses and Liquid Smoke in Smokehouses

3.8.1 Smokemaking equipment and ducts must be of non-corrosive material and designed for easy cleaning of all inner and outer surfaces.

3.8.2 Liquid smoke must be chemically acceptable. Spray heads, for dispensing liquid smoke, must be mounted below the level of the rails and trolleys. If liquid smoke is to be recirculated, the pump and pipelines must be of sanitary type construction. Liquid smoke cannot be recirculated if product is on rack trucks. Vaporized liquid smoke procedures must be approved by the inspection standards and regulations group.

3.9 Lubricants

3.9.1 Equipment in which lubricating grease or oil is used shall be designed to prevent the contamination of product by lubricating material. As a further precaution against the inclusion of toxic compounds in product, all lubricants used in areas where potential contamination exists must be edible and specifically approved by the Food Ingredient Assessment Division, Science, FSIS.

4.0 Equipment Installation

4.1 Certain requirements on the placement, arrangement and installation of equipment have been established to permit convenient, positive cleaning. Constant attention must be given to these details in order to maintain an orderly flow and clean handling of product. The initial installation of equipment and every change in operations must be carefully analyzed for potential sanitation problems. Any circumstances that could result in product contamination should be avoided.

4.2 Major pieces of equipment must be shown on approved blueprints before installation is permitted. When equipment is installed on an experimental basis, drawings showing its location on floor plans must be submitted within 30 days after acceptance.

4.3 **Spacing from Floors, Walls, and Ceilings**: All parts of stationary (or not readily movable) equipment must be installed far enough away from floors, walls, and ceilings to provide access for cleaning and inspecting. As an alternative, permanently mounted equipment may be sealed with a watertight seal to the adjacent structure. Wall mounted cabinets and electrical connections must be installed at least 1 inch from the wall or sealed watertight to the wall.

4.4 **Water Wasting Equipment**: Water waste equipment shall be installed so that waste water is delivered through an interrupted connection into the drainage system without flowing over the floor, or shall be discharged within a properly drained, curbed area. Cooking tanks, soaking tanks, chilling tanks, and other large vessels may be discharged across the floor for short distances to a drain after operations have ceased and product has been removed from the area.

4.5. **Protection of Water Supply**: An air gap shall be provided between the highest possible level of liquids in equipment and water supply pipes. Functional vacuum breakers must be provided in installations

CHAPTER 19

INSECT AND RODENT CONTROL

1.0 The information in this chapter supplements Parts 8.46 through 8.51 of the Meat and Poultry Inspection Manual.

2.0 Sound **sanitation**, construction, **maintenance** and **exclusion** programs are the first line of defense for pest control. Pesticides are a backup system or second line of defense. They are poisons and, therefore, can cause secondary problems. Therefore, chemicals must not be allowed to become the primary insect and rodent control program. A plant that becomes dependent upon chemicals and ignores the other control measures, increases the risk of chemical contamination of product. There is also increased risk from pests that bypass the poison or become chemically resistant.

2.1 A sound **sanitation** program removes the food and water supply that attracts and supports a pest population. It also eliminates the debris that provides nesting and hiding places.

2.2 A sound **construction** program for new or rebuilt structures creates a barrier that prevents the entry of pests from the outside. It also impedes or stops their movement within the building.

2.3 A sound **maintenance** program assures that breaks in the construction barriers are promptly corrected. For example, holes in the outer surface of block walls permit rodents and insects to enter the wall and to move at will until an internal opening is found. Maintenance must close cracks and crevices in inner and outer surfaces to restrict access to pests. The closing of one access will cause the pest to seek other access points. The maintenance staff must receive the support of the entire management team to help identify the access points until the facility is adequately sealed.

2.4 A sound **exclusion** program prevents the entry of pests through the necessary openings in a building. Screens on windows, fly chaser fans, and self-closing tight fitting doors are a few examples.

2.4.1 Pests often enter a plant inside cartons that contain supplies. They also lay eggs in cartons during off-premises storage and they may later hatch inside the official establishment. The pests and their eggs can be excluded by uncasing the supplies in the receiving area. The cartons must go directly to the trash disposal system. The supplies of cans, jars, plastic jugs, plastic bags of supplies and other items are placed on sanitary shelves or racks, on mobile storage carts, or in lugs for distribution to the work stations.

2.4.2 Corrugated box blanks on pallets are frequently the source of new cockroach infestations. The female lays eggs in the open corrugations at the edge of the boxes. To exclude the insects, treatment outside the official establishment is necessary. Fumigation may be practical but it must be done in a proper facility by qualified fumigation personnel. Moist heat in an enclosed area has also been used with success. Heat can be used to treat anything that will not be damaged by high temperature.

2.4.3 Nocturnal insects are attracted by the ultraviolet (Ultraviolet) light rays from mercury vapor lamps. Such lamps should be positioned at least 100 feet from plant openings. Very little U.V. light is emitted by high pressure sodium vapor lamps. Therefore, they may be used to illuminate loading docks, doors, and other entry ways. The intensity should be kept as low as practicable to avoid attracting insects. Reflectors direct the light to the work zone. They also help to prevent the attraction of high flying insects.

2.4.4 Insect electrocutors (U.V. light traps) attract insects. Therefore, indoor units must be placed where they cannot be seen from the outside through openings in the building. Ultraviolet traps for flies in a building are most effective at about eye level. Ultraviolet traps for nocturnal insects that enter a building are most effective near the ceiling. The traps must not be placed over product or the product trucking aisle. They should be placed as close as practicable to the potential point of insect entry. Also, avoid placing the trap in a location that will cause the insect to cross over product or a product trucking aisle.

2.4.4.1 Direct sunlight cancels the effectiveness of an ultraviolet light emitting trap. Therefore, during the day, they should be placed in outside shadowed areas, under a roof such as in the livestock pens, and in dimly lit areas of a building.

3.0 Chemical Pest Control

3.1 This is a backup system to control pests that penetrate the exclusion system. The inspector must be thoroughly familiar with the guidelines in the Meat and Poultry Inspection Manual. The chemicals identified in the Manual may be used only if they are identified under the manufacturer in the "List of Authorized Proprietary Substances and Nonfood Compounds" (formerly the "List of Chemical Compounds"--miscellaneous publication no. 1373). Other manufacturers may have the same active ingredient and may not be listed. If so, their product cannot be used in an official establishment. The latter may not be listed simply because they did not make application. They also may not be listed because their product contains other ingredients that are not acceptable.

3.2 The Environmental Protection Agency (EPA) is responsible for the registration and labeling of pesticides. FSIS cannot be less restrictive

CHAPTER 20

SANITARY DRESSING PROCEDURES, IN GENERAL

1.0 Sanitary handling of meat begins with the slaughter and dressing operations. Effective control over sanitary dressing procedures is vital to the production of a clean, wholesome and safe product.

2.0 The attitude and ability of plant employees, the class and condition of livestock slaughtered, and the design and construction of plant and equipment all contribute to the relative difficulty in obtaining clean carcasses.

3.0 Sanitation of farms and feed lots and adverse weather conditions also are significant in the implementation of sanitary dressing procedures.

4.0 Construction, drainage and sanitation of the plant livestock holding facilities are extremely important, since livestock moves through them to slaughter.

5.0 The internal tissues of a normal, healthy, living animal are virtually sterile. The live animal has two main exposures to the outside environment:

5.1 One is its protective covering of skin or hide which in turn is covered with hair manure, dirt, etc.,--in itself a source of objectionable contamination. But of even more significance, these potential contaminants contain a wide variety and exceedingly large number of microorganisms;

5.2 The other main exposure is that of the gastrointestinal tract which is in reality a long tube extending from the mouth to the anus into which food is consumed, digested, and from which wastes are excreted. Not only are microorganisms injested with the feed and water, but their propagation and growth are very significant parts of the digestive process, so much so that much of the fecal mass is actually a concentration of microorganisms in astronomically large numbers. The respiratory system and reproductive and urinary tracts may be exposed to the outside environment and are potential sources of meat contamination.

6.0 It is the principal objective of sanitary dressing procedures to remove or clean the hide or skin and to remove the gastrointestinal tract and other internal organs with minimum contamination of the meat. The process is difficult enough in healthy animals. It is more complicated in animals with localized or generalized diseases, many of which are not detected until the dressing operation has been partially or entirely completed. Since inspectional procedures are designed to detect and remove these abnormal conditions and since it is not known with certainty prior to inspection of all the animals which are affected, sanitary dressing procedures must be designed to eliminate common contact of skinned carcasses and parts prior to inspection. This is also the basis for requiring cleaning and disinfection of certain instruments and equipment between each use (i.e., dehorning equipment, knives used to sever hog heads, brisket knives or saws, moving top viscera tables, etc.).

7.0 The diseased animal may also pose a serious contamination threat and public health hazard via other tissues and fluids, such as bile, urine, milk and fluids and tissues from the reproductive tract. These are considered as objectionable types of contamination in all animals.

8.0 All diseased tissues and associated fluids (such as pus) must not be allowed to unnecessarily contaminate product, workers, equipment or environment. When such contamination does occur, by accidental or other means, strict, careful correction must be immediately accomplished. This again emphasizes the necessity of plant and equipment being designed, constructed and arranged so that they are easy to clean.

9.0 The slaughtering and viscera separation departments, in addition to handling a large volume and variety of clean and unclean materials, are supplied with abundant moisture and warm temperatures. This is ideal for rapid growth of microorganisms; therefore, strict sanitation and orderly handling of product to insure rapid chilling are essential.

10.0 The "final" veterinary inspector is the immediate supervisor of the slaughtering and related departments to which he is assigned. He is responsible for all matters pertaining to inspection. This applies not only to the actual final inspection of retained carcasses but also to the sanitary condition of the premises, sanitary dressing procedures, the condition and operation of equipment and the work of FSIS employees who may be under his supervision.

11.0 Inspectors assigned to post-mortem duties are responsible for seeing that sanitary dressing procedures are followed. They should observe the condition of rooms, equipment, and clothing of plant employees to see that they are clean and that the equipment, including disinfection units, wash basins, and facilities for inspection, are in proper working order.

12.0 Each inspector should constantly observe the maintenance and use of disinfection units and wash basins during operations and require that they be properly maintained and used.

13.0 The following are general guidelines of sanitary dressing applicable to all species of livestock slaughtered:

13.1 The first and paramount rule of sanitary dressing is to avoid any contamination of edible portions of the carcass with materials such as feces, urine, hair, ingesta, milk, bile, pathological tissues and exudates, and other filth. All controls of slaughter and dressing procedures must be aimed at accomplishing this purpose. It is essential that this basic rule is observed as the first guideline for control.

CHAPTER 22

DRESSING OF SWINE

1.0 Stunning and Bleeding

1.1 Sanitation in the livestock holding pens, drive alleys, restraining chutes, and stunning areas should be consistent with those requirements outlined for cattle.

1.2 Sticking must be done properly to insure complete bleeding and to prevent shoulder wounds that become heavily contaminated during scalding, dehairing and polishing operations. Animals should not enter the scalding tank prior to death.

2.0 Scalding

2.1 Mechanical exhaust should be provided above the scald tank or in an adjacent exterior wall.

2.2 The scalding tank must be drained and cleaned daily. Fresh clean potable water must be used at the start of each day's operation. Some of the factors influencing effective scalding include water circulation and temperature, number of carcasses, and time carcasses remain in the tub.

2.3 The temperature of the scald water should be adequate to insure clean carcasses. (Optimum scalding temperature is usually considered to be 138° to 140° F. but may vary with some facilities.) If additives are used in the scald water, they must be approved.

2.4 Carcasses should remain in the scald tank only a sufficient time to loosen the hair. Excessive time in the tank or excessive temperature may result in cooking of carcass and breaking of the skin with resulting contamination.

3.0 Dehairing and Gambrelling

3.1 Dehairing machines must be maintained in good working condition to efficiently remove hair from the animals. The water temperature and number of carcasses through the machine also influence cleaning.

3.2 In either single or multiple unit spray-type dehairing machines, water may be recirculated in the first two-thirds of the system. Clean water must be used in the last one-third of the system or at least for the last 6 feet.

3.3 Hind feet are to be cleaned of hair and scurf before gambrelling. If hogs are dipped in rosin, nostrils and mouth should be closed by rubber bands prior to dipping.

4.0 Singeing, Polishing, and Other Cleaning Operations

4.1 The singer should be equipped with an automatic cutoff and starter switch to prevent burning of hogs when the chain stops. If a polisher is used, it should be used with a water spray and function properly.

4.2 Complete removal of dirt, hair, scurf, and rosin must be accomplished prior to heading. Carcasses are not to be washed after heading and prior to inspection. It is important that the establishment properly clean hog carcasses **before** any opening is made for dropping the head or evisceration. These requirements are designed to prevent hair contamination of cut surfaces.

4.3 Inspectors assigned to cervical inspection are required to inspect carcasses to determine whether they have been properly cleaned. Inspectors can assist the management of establishments by pointing out many of the above factors that influence satisfactory scalding, dehairing, and cleaning. These factors may vary considerably in different installations and with the type of hogs slaughtered; however, given adequate attention, there should be no difficulty in obtaining satisfactorily cleaned carcasses.

5.0 Head Dropping and Evisceration

5.1 Due primarily to the frequency of abscesses and tuberculosis in the cervical area of swine, the knife or other tool used to partly sever the head must be disinfected after each head is dropped. The inspectors assigned to cervical inspection are responsible for enforcing this requirement. No shaving should be done after the head is dropped.

5.2 When necessary to prevent contamination of the carcass or viscera, the rectum must be tied before evisceration. For the same reasons expressed under cattle dressing, the brisket knife or saw is to be disinfected after use on each animal. When opening the carcass, the knife should be used in a manner that prevents cutting the viscera or urinary bladder.

5.3 Establishment employees should exercise care to prevent cutting of intestines, stomach and gall bladder. Carcasses contaminated by stomach or intestinal contents or bile must be thoroughly cleaned before being presented for viscera inspection.

5.4 Those organs excessively contaminated should be condemned. If any part of the carcass is contaminated with pus or other pathological exudate, it must be trimmed under the supervision of an inspector. Contaminated equipment should be washed with cold water prior to disinfecting in 180° F. water.

5.5 The viscera inspector should observe the carcasses and, insofar as possible, the methods establishment employees use in handling carcasses and parts. Establishment employees are required to disinfect implements after their use on retained carcasses.

6.0 Splitting and Trimming

6.1 If there is evidence of abscesses, ham facings are to be removed and condemned. Castration scars, pizzles and related tissue, if present, must be removed. The saw or cleaver used to split retained carcasses is to be disinfected after each such use.

6.2 Necks of all carcasses are to be trimmed to remove blood clots. Stick wounds and any other tissue contaminated by scald water must be trimmed or otherwise acceptably cleaned. All areas where there are breaks in the skin prior to or during scalding, dehairing or polishing, must be effectively trimmed to remove all contaminated tissue.

6.3 The necks of hog carcasses may be washed after removal of the leaf and scrap fat. The skimmings from the tank receiving the water from neck washing should not be used for edible purposes.

6.4 After the completion of inspection and dressing operations a final wash may be used for the removal of bone dust.

5.6 Building and Extending

[illegible]

2.15 The use of aluminum should be avoided, if possible, due to potential staining of product through contact or friction. If it must be used, staining can largely be avoided by the use of anodized aluminum hooks, rails, pipes, and sheets. The anodic coating may erode in time and anodizing becomes necessary to prevent contamination of product.

2.15.1 Use of hard metal hooks, such as galvanized iron or stainless steel on aluminum rails, may cause abrading of the rail surface and deposit of small particles of metal on the product.

2.16 Staples from metal stitching machines represent a dangerous source of contamination. Operation of the machines near open containers of product should not be permitted.

2.16.1 Metal-stapled containers and wirebound boxes of product should be opened with great care.

3.0 Livestock Pens

3.1 To avoid dust and odors, holding and shackling pens should be located outside of, or effectively separated from, the slaughtering department by full-height partitions of impervious material.

3.2 The livestock pens must be paved with impervious material, such as concrete or brick, and pitched to suitable drainage facilities. Except at entrances, curbs of at least 12-inches high of impervious material, such as concrete, are to be provided around the borders of the livestock pen area to confine liquids and material.

3.3 Well-located hose connections must be provided for the cleanup of the livestock pens. Watering troughs should be located over, or adjacent to, pen floor drains and be equipped with suitable overflow outlets.

3.4 A reasonable portion of the livestock pens, including the area with the suspect pen and squeeze gate should have a weathertight roof.

4.0 Slaughter

4.1 Slaughtering departments must have adequate floor space and be arranged to facilitate the sanitary conduct of operations and the efficient performance of the inspection.

4.1.1 Truck ways over which products are conveyed from the slaughtering department to other rooms (such as the offal cooler, the edible products tank charging rooms, and the inedible products tank charging level) should be located so that the material is not trucked beneath rails from which dressed carcasses and product are suspended.

4.2 The rate of slaughter is dependent on the ability of the establishment to present carcasses, their viscera, and parts in an orderly and clean manner which permits a complete and efficient inspection at all times and does not create congestion or other objectionable conditions of any kind.

4.3 A suitable room or space and facilities for washing gambrels, beef hooks, trolleys, etc., is to be provided in a convenient location and an exhaust fan should be installed in an outside wall for dispelling steam.

4.4 Oil must be drained from trolleys, gambrels, hooks, etc., prior to use. Dipping oils are to be kept free of floating debris and foreign film by frequent skimming to avoid transfer to trolleys, gambrels, hooks, etc.

4.5 Scabbards, chain belts, and similar devices for the temporary retention of knives, steels, triers, etc., by workers and others should be constructed of rust-resistant metal or other impervious material. They should be of a type that can be readily cleaned and should be kept clean.

4.6 When viscera inspection trucks are used, a separately drained area about 7 by 8 feet in size is required for cleaning and disinfecting such equipment. These facilities should be located at or near the point where condemned material is discharged from the trucks.

4.6.1 The truck washing area should have walls 8 feet or more in height when placed where splash might contaminate edible product. The floor in the area should be pitched about ½-inch per foot to a drain in a rear corner.

4.6.2 A hose for washing trucks with an ample volume of water at a temperature of at least 180° F. is required in the washing area. The hot water must be obtained from a central supply (rather than by mixing steam and water at or near the hose connection) and a dial-type thermometer with its temperature sensitive element located in the hot water line near the hose connection is required.

4.7 In moving flight-top inspection tables, a suitable compartment-type flight washer and disinfection unit is required at the proximal end of the table. The compartment must be provided with a vent pipe to the outside air. This duct must be constructed of rust-resistant metal and be at least 10 inches in diameter.

4.7.1 The required thermometer must have its sensitive element in the hot water line as it enters the disinfection compartment. The temperature recording scale must be located so that it can be readily observed by the inspector working alongside the inspection table.

4.7.2 Cold water sprays to remove blood, animal tissues, and fluids from the flights before disinfection are required for the returning flights as the distal end of the table. Additional cold water sprays are also necessary to cool the flights immediately following disinfection.

4.8 Fountain-type brushes are not acceptable for washing carcasses and parts.

4.9 Carcass shroud cloths should be thoroughly rinsed following washing to assure the removal of all soap or detergent compound.

4.10 A properly constructed hide chute should be provided near the point where hides are removed from carcasses. The chute should have a hood of substantial rust-resistant metal with a push-in door closely fitting an inclined metal frame that is self-closing by gravity. A vent pipe at least 10 inches in diameter must extend from the hood vertically to a point above the roof.

4.10.1 If hides are removed from the department by some means other than a chute, the facilities must be designed to create no problems of sanitation.

4.11 The spreading of hides for inspection in the slaughtering room is not permitted.

4.12 Hog hair must be removed from the slaughtering room in water-tight metal containers at least once a day at the end of the day's operations and hair must either be removed from the plant in a watertight metal truck and disposed of in such a manner as to not create objectionable conditions, such as fly breeding or odors, or it can be conveyed to suitable equipment for processing in the plant.

5.0 Viscera Separation

5.1 Suitable facilities for holding edible organs and parts (offal) under refrigeration in a separate cooler or in a separately drained part of a carcass cooler are required. Such areas must be accessible from the slaughtering department without passing through a line of carcasses or through a congested carcass cooler.

5.2 Since the opportunities for contamination are great and product is handled at temperatures conducive to bacterial growth, it is important that inspectors of viscera separation operations be especially alert to any condition adversely affecting the prompt, clean handling of warm offal products.

5.2.1 The inspector should be thoroughly familiar with both product and handling procedures. It is important to discourage excessive accumulation of any unworked product. Such products must be chilled as rapidly as possible in line with good commercial practice.

5.3 Edible offal should be placed on cages with removable metal drip pans beneath, on suitable trucks provided with similar drip pans, or otherwise suitably conveyed to the offal cooler.

5.3.1 If offal is packed in the coolers, suitable facilities including a table and lavatory should be provided.

5.4 The paunch emptying table must be constructed of rust-resistant metal. The end of the table should overhang the emptying hopper about 12 inches to avoid soiling the cut and serous surfaces of paunches.

5.4.1 The sides of the hopper should extend vertically below the top of the table at least 3½ feet and converge to a discharge opening at least 8 inches in diameter. This is necessary for the prompt removal of paunch contents without undue contamination.

5.5 Cattle paunches and hog stomachs used in the preparation of meat food products must be thoroughly cleaned on all surfaces and parts immediately after being emptied of their contents. This should promptly follow their removal from the carcasses.

5.6 Heads used in the preparation of meat food products should be split and the bodies of the teeth, the turbinate and ethmoid bones, ear tubes, and horn butts removed; then the heads should be thoroughly cleaned.

5.7 Kidneys used in the preparation of meat food products should first be freely sectioned and then thoroughly soaked and washed.

5.8 Many hog tongues are lacerated and soiled during and following the dressing operations. The mutilation is caused in large measure by the action of the beaters of the dehairing machine.

5.8.1 When this condition exists, all lacerations and punctures in the tongues must be removed by excision. Stained mucous membranes must be removed by scalding. The trimming of tongues and removal of mucous membranes should be regarded as a part of the dressing operation.

5.9 Pharmaceutical products should be prepared, collected, and stored in such a manner that no sanitation problem exists. There should also be no interference in the preparation or inspection of edible products.

6.0 Inedible and Condemned

6.1 Well-arranged and adequate facilities for handling inedible and condemned material should be provided at slaughtering plants. Inedible products departments must be separate and distinct from those used for edible products, except for one connecting doorway provided with a solid, self-closing door connecting the tank charging room of the inedible products rendering department and the slaughtering or viscera separating departments. The door must completely fill the opening.

beans should receive a preliminary inspection. They may be brought into the establishment unless affected with a condition such as heavy mold, sourness or weevil larvae, webbing, or refuse which could not be removed by the cleaning procedures.

7.22.1 Beans from an acceptable lot should not be used in product until the cleaning process has removed all foreign material (stones, dirt, weed seeds, and cereal grains) and beans damaged by insects.

7.22.2 Beans less severely damaged by insects (in which the seed coat is slightly affected) and those slightly damaged by frost, weather or disease may be included in product. Broken beans and beans with the seed coat partially or wholly removed may also be included.

7.22.3 Establishments not having bean-cleaning facilities should receive only beans entirely free of defects that make them unsuitable for inclusion in products. All beans should be thoroughly washed before use.

7.23 Several types of machines used to overwrap cartons of product, such as sliced bacon, luncheon meat, frankfurters, etc., are designed in a manner requiring product in a carton to be conveyed beneath the heat sealing unit before the wrapper is applied.

7.23.1 Inspectors should closely examine such equipment to determine if the construction permits product contamination. If so, the establishment should be required to install a removable rust-resistant metal tray just below the heat sealing unit.

7.24 The edges of shovels should be ground as often as necessary to prevent the rolling edges from crumbling into product. Cast alloy shovels made of the softer metals require close attention.

7.25 Worn can openers, metal cut by friction, broken or worn parts of equipment, wire used to suspend overhead equipment, loose hooks on cooler racks, metal strapping from fiber containers, and broken wire from bacon hangers and belly spreaders are all sources of metal contamination which should be given careful attention.

7.26 The pusher bar of some frozen meat choppers feeds frozen blocks of meat to the chopping blade. There is a space of a quarter inch or more between the pusher bar and the bed of the chopper. This space allows the accumulation of product and fluids that can serve as a source of bacterial contamination.

7.26.1 The pusher bar should be removed at the close of a day's operation and thoroughly cleaned. It should be left unassembled and allowed to air overnight.

7.27 The feeder screw of most meat grinders is cast, and the center consists of a hollow core. It is very important that close examination be made of such equipment to detect any crack, flaw, or faulty construction that would result in an unsanitary condition.

7.28 The hollow arm in some band saws contains a small opening on the top side. This opening allows cleanup water and other contaminants to enter the saw arm and become sour and decomposed. The problem can be corrected by placing a clean-out opening or plug on the lower side of the arm.

8.0 Coolers, Boning, and Cutting

8.1 Cooler rails must be placed at least 2 feet from refrigerating equipment, walls, columns, and other fixed parts of the building. To promote cleanliness of product and to protect walls from damage by carcass shanks, it is desirable to place rails (especially header or traffic rails) at least 3 feet from the walls.

8.2 Metal tag fasteners used to apply numbered identification tags in the slaughtering departments should be removed after they have served their purpose. Other metal tag fasteners, tags, wood and metal skewers, etc., should be completely removed from carcasses prior to cutting or boning.

8.2.1 Tag fasteners that cannot be readily removed from the meat should not be permitted.

8.3 Cutting boards should be as small as is practical for the purpose. Such boards should be kept smoothly planed and removed daily for cleaning on all surfaces.

8.3.1 For more detailed requirements refer to "cutting and boning boards" listed under the equipment section of this handbook.

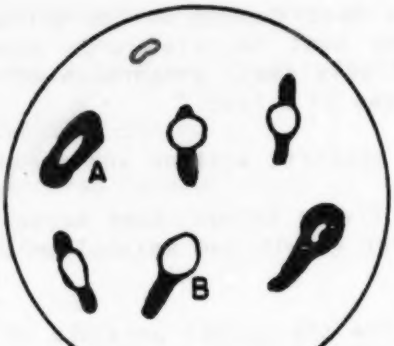
8.4 Mechanical slicing of unfrozen pork jowls, with acceptable inspection by a competent establishment employee of each cut surface immediately after slicing, is required for jowls intended for use in fabricated products or in rendering.

8.4.1 Facilities must be provided for cleaning and disinfecting these mechanical slicers each time they become contaminated. This is usually accomplished either by a cleaning and disinfection hood that can be lowered over the machine, or the machine itself be rolled into a disinfection cabinet. When the latter method is used, it is desirable that a second slicing machine be available so production may continue while the contaminated machine is being cleaned and disinfected. The inspector must be assured that this cleaning and disinfection procedure is being properly accomplished.

2.9.5 Most shelf stable canned foods must be subjected to a very high temperature under pressure in order to destroy any dangerous spores possibly present. The spores of greatest concern in canned foods are those of the botulism organism which when growing in the vegetative state produce a highly fatal toxin (poison).

2.9.6 The incubation period on canned items is required for assurance that the heat process was sufficient to destroy spores. During this period any surviving spores would have time to become vegetative cells and begin the growth curve and lead to a swollen can or show other sign of spoilage.

2.9.0 Figure 1



A. Botulism spore B. Tetanus spore

BACTERIAL SPORES

2.10.0 Environmental Factors

2.10.1 The environment normally determines the types of bacteria present (the flora). This is a very important fact and offers a tremendous safety factor as we are able to change the environment, and thus to a great extent, control or change types of organisms present.

2.10.2 With meat we actually start with a virtually sterile environment in the flesh of a healthy living animal. After the animal is killed, the situation changes rapidly. The natural defenses of the animal (blood, lymph, uncut skin) fail to prevent the entry of bacteria.

2.10.3 Various steps in the processing plant add or distribute the bacteria, or destroy them. Other steps change the environment so their growth (reproduction) is controlled. With each change in the environment, the bacterial flora and their related problems change.

2.11.0 **Nutrition.** Different species of bacteria have different food requirements which the environment must provide. All bacteria require a carbon, nitrogen and energy source; trace minerals; and abundant moisture for growth. These things are found in abundance in the proteins, carbohydrates, fat, water, salt, nitrate, etc., in meat processing plants. Therefore bacteria have little trouble finding adequate nutrients.

2.11.1 Bacteria have no digestive tracts. Therefore, they secrete enzymes outside the cell wall to break down nutrients to be reabsorbed into the cell. This process is responsible for most of the desirable and undesirable effects of bacterial growth (such as fermentation, putrefaction, etc.).

2.11.2 Since the bacteria must depend on the diffusion of digested material back to them, they must secrete large quantities of enzymes. This means that a relatively small proportion of bacteria, by weight, can made profound changes in a food.

2.11.3 Enzymes have very specific actions and are identified by this action.

2.12.0 **Oxygen**. Like all living things, some bacteria need oxygen to convert matter to energy for growth and metabolism but they vary in the means of obtaining it.

2.12.1 Some bacteria require the actual presence of free oxygen such as that found in the air. These organisms are known as **aerobes** and without this supply of free oxygen they cannot grow.

2.12.2 Vacuum packaging was conceived primarily to inhibit the growth of aerobic organisms. The lack of oxygen may not destroy the aerobic organisms entirely but they become inactive or dormant and if air becomes available again, they will begin growing and reproducing

2.13.0 **Anaerobic** organisms on the other hand satisfy their need for oxygen chemically through organic or inorganic compounds in their environment. Therefore, air or free oxygen is not required and actually can be very toxic to them.

2.13.1 Anaerobic organisms, important in meat, thrive in insufficiently heated or perishable canned items, vacuum packaged products, within the interior of sausage and cured meat products, or any other place devoid of oxygen. Anaerobic organisms can cause fermentation, a useful function in cheese, dry sausage, sour milk, etc. They can also be responsible for canned food spoilage and botulism.

2.14.0 **Facultative anaerobes** are organisms that will grow either with or without free oxygen. These organisms can cause considerable confusion to the novice.

3.1 Yeasts and molds are both fungi and contain no chlorophyll. They are not in the same classification as bacteria but do have many characteristics in common. Some of the principal characteristics of yeasts and molds can best be summarized in the following ways:

3.2 Yeasts

3.2.1 Are falcultative anaerobes - they can grow with or without air.

3.2.2 Capable of growth at low temperatures and at acid pH.

3.2.3 Utilize sugar mainly as a nutrient and are able to convert starch to sugar.

3.2.4 May be increasingly important as a meat contaminant.

3.2.5 Principally a surface problem (particularly in bologna and franks).

3.2.6 Exceedingly difficult to control.

3.2.7 Generally not considered harmful.

3.2.8 Reproduce by budding.

3.3 Molds

3.3.1 Are aerobic - they must have air for growth; therefore, they grow on the surface only.

3.3.2 Capable of growth at low temperatures (even below freezing).

3.3.3 Can grow well in an acid pH (such as fermented sausage).

3.3.4 Thrive on meat nutrients particularly the sugar and protein.

3.3.5 Are large enough to be seen by naked eye. Appear as white, green, or black fuzzy or hair-like growth. (The "whiskers" on aged beef are molds.)

3.3.6 Will grow in the presence of high salt.

3.3.7 Will grow in low moisture.

3.3.8 Molds are generally not considered harmful. They are commonly found on a variety of processed meat products such as dry sausage, hams, bacon, etc. Molds cannot compete with the common spoilage bacteria found on fresh meat. They usually are not seen unless fresh meat is held for prolonged times in a relatively dry area such as would be found in an aging cooler.

4.0 Useful Microorganisms

4.1 There are many ways in which microorganisms serve man. Three specific areas of usefulness in meat operations are worthy of brief consideration:

4.1.1 **Nitrate Reduction**. When nitrate is used as a curing ingredient, it must be converted to nitrite before it can combine with muscle pigments to form the pink color, characteristic of cured meats. The conversion of nitrate to nitrite requires the growth of a certain type of bacteria.

4.1.1.1 For years these nitrate-reducing bacteria were indispensable in meat curing. The processor had to depend upon large numbers of them being present in order to obtain properly colored cured product.

4.1.1.2 The addition of nitrites directly to product has now gained extensive use and has diminished the importance of these organisms.

4.1.2 **Fermented Sausage**. The "tang" so characteristic of many varieties of dry sausage (Genoa salami, thuringer, Lebanon bologna, etc.) is derived as a direct result of bacterial growth. Certain species of bacteria are capable of converting sugar into various acids. The principal acid being lactic acid; thus these bacteria are known as "lactic acid bacteria."

4.1.2.1 The greater the acidity (low pH) produced within the product the more "tang" it will have. The sausage maker must be sure the emulsion contains sufficient numbers of lactic acid bacteria to get desirable fermentation and tang. Such sausage is made by either adding a commercially available "starter culture" of lactic acid bacteria or adding enough of the specially handled ground finished sausage to the new emulsion to assure fermentation.

4.1.2.2 This sausage is then placed in a warm room (often called the "green room") for a period of time to allow the bacteria to begin growing. The fermentation is then completed in the drying rooms.

4.1.2.3 If the lactic acid bacteria do not get a good start, other types of bacteria may grow instead, causing spoiled--possibly even hazardous--product.

4.1.3 **Indications of Spoilage**. In time, all meat products will spoil, each type in a characteristic manner. This so-called "normal spoilage" pattern is important because it serves notice to the consumer that the food should not be eaten.

4.1.3.1 Many times the organisms that produce the foul odor, off color, or slimy sticky surface are not in themselves harmful to human health but they indicate that the product has been mishandled or is spoiled and may contain pathogenic organisms or dangerous toxins produced by organisms which may give no gross indication of their presence.

5.2.1.4 Another example of the importance of initial numbers of organisms can be found in sausage. The shelf-life of franks (or any other sausage) is greatly influenced by the number of organisms originally present in the emulsion.

The franks will spoil much faster if made with meats of questionable quality or with excessive amounts of rework products or under poor sanitary conditions than a similar product held under identical post-processing conditions but made with sound, clean ingredients, minimal or no rework product, and under good sanitary conditions. Similar examples can be quickly seen in all phases of meat operations.

5.2.1.5 The importance of sanitation cannot be overemphasized in maintaining a low level of contamination from microorganisms to insure a more wholesome product with a longer shelf-life.

5.2.2 **Physiological age of bacterial culture**: A closer examination of the growth curve reveals that during the growth phase the bacterial cells are the most active. They are in a sense, physiologically young cells, whereas those cells found in the resting and death phases are physiologically old cells.

5.2.2.1 If contamination occurs from bacteria in the growth phase, then the lag phase is considerably shorter than it would be if the cells were from the resting or death phases.

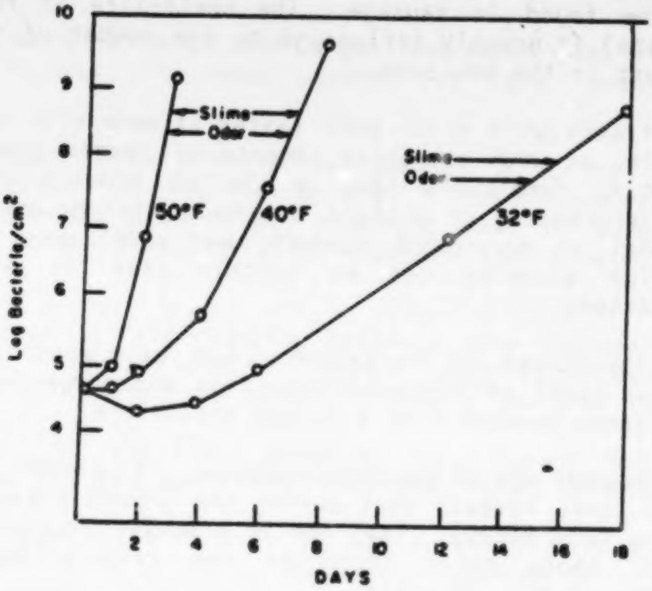
5.2.2.2 From a practical standpoint, one can conclude that contamination from a slicer is much more important than from the air. The bacterial cells in the air are generally dormant due to a lack of nutrients and moisture while the bacteria on the slicer are likely to be young, active cells in or near the growth phase.

5.2.3 **Type of Organisms**: In meat spoilage, the psycrophiles are the most important group of organisms because by definition they are capable of growth at cooler temperatures. Therefore, when decomposition is the primary concern, contamination from the cooler is more critical than that received from other locations.

5.2.4 **Temperature**: As the temperature drops the lag phase becomes longer. Also the growth rate will be slower in colder temperatures. There is a law of chemistry which says that the speed of a chemical reaction doubles with each 10°C. rise in temperature. Bacteria can be considered as bundles of chemical reactions.

5.2.4.1 The following chart illustrates the effect of temperature on the length of the lag phase and the growth rate of a common meat spoilage organism.

5.2.4.1 Figure 1



6.0 Spoilage Problems

6.1 **Fresh meat**. The bacterial problems in fresh carcass meat are largely on the surface such as slime, odor, stickiness, off color, off flavor, etc. This is due to the bacteria being limited to the surface areas of the product.

6.1.1 Subsequent operations such as cutting, boning and grinding will introduce bacteria to additional surface areas and spoilage will occur throughout the product and at a much more rapid rate.

6.2 **Cured meat cuts**. Cured meat cuts such as hams, briskets, rounds, etc. will have surface and internal spoilage problems. Mishandling of products before curing or subsequent faulty curing and processing cause the majority of problems in items such as ham and bacon.

6.2.1 The curing pickle injected into the product or used as a cover pickle must be handled in accordance with strict sanitation principles. It should be remembered that the longer the time the product is in a cover pickle, the more susceptible it becomes to bacterial problems.

6.2.2 Pumping pickle should not be prepared too far in advance of its use and must be handled in a clean manner.

6.3 **Sausage products**. Sausage products have more bacterial problems than any of the other cured items. Sausage is rich in nutrients, contains ample moisture, and is prepared and processed under a variety of environmental conditions favorable to microbial growth.

Also, a special study may be made of operating procedures to detect the contamination source, and appropriate improvements in sanitation will be required.

4.3.3 The same procedure outlined above for handling suspicious heat processed products will apply to raw products also. Recall request will be initiated only at the Washington level.

4.4 Inedible Rendering

4.4.1 The renderer should pay particular attention to Salmonella contamination of packing house byproducts such as tankage, meat scraps, blood meal, etc., that are used for animal feed. The rendering process is more than adequate to destroy all Salmonellae present. Therefore, the principal problem in this area is recontamination following processing.

4.4.2 For many years, very little inspectional attention was given to these areas other than from the standpoint of general sanitation, control of condemned and inedible materials, and the prevention of a nuisance in or around the plant. This has resulted in the development and use of rendering equipment that is poorly designed and constructed from a sanitation standpoint and in many older installations the equipment is impossible to effectively clean. Newer and future installations should be designed to correct this problem.

4.4.3 Also of prime importance is the recontamination occurring as a result of workers handling the raw and finished product and/or the use of shovels, trucks, and other equipment for both the raw and cooked products. This should be strictly avoided. Birds, rodents, and insects also can be vehicles of contamination and their exclusion and control is vital.

5.0 Other Food-Borne Illnesses

5.1 Although there are other bacteria able to produce food-borne illnesses, from a sanitation point of view their prevention and control are so similar to be ones mentioned that further discussion is of little real value.

5.2 The following charts will provide a brief summary of the various significant bacterial food-borne illnesses:

CHART NO. 1

CHARACTERISTICS OF BACTERIAL FOOD POISONING

DISEASE AND AGENT	INFECTION	INTOXICATION	SYMPTOMS AND TIME OF ONSET
Botulism *Clostridium* *botulinum*	-	+	Difficult swallowing, double vision, paralysis of breathing muscles. Two hours to eight days. Mortality 65%
Staphylococcus food poisoning. Certain strains *Staph*. *aureus*	-	+	Nausea, vomiting, diarrhea, cramps, and acute prostration. One to six hours. Occasionally 24 hours.
Salmonella infection *S*. *typhimurium* *S*. *enteritidis*; other *S*. species	+	-	Abdominal pain, chills, fever, diarrhea, vomiting, prostration, and sometimes septicemia. Seven to 72 hours.
Streptococcus food poisoning *Streptococcus* *faecalis*	+	-	Nausea, sometimes colicky pains, vomiting, and diarrhea. Two to 18 hours.
Cl. *perfringens* *B*. *cereus* paracolon sp. *Proteus* *vulgaris*, etc.	+		Same as Streptococcus

CHAPTER 30

PLANT PERSONNEL

1.0 Introduction

1.1 Clean personnel with clean habits are essential to sanitary production of meat and poultry products. Clean hands, clean clothing and hygienic practices reduce the likelihood of contaminating product and product-contact surfaces of equipment, utensils and packaging materials.

2.0 Disease Control

2.1 Disease transmitted through meat food products frequently originates from an infected meat handler. A wide range of communicable diseases and infections may be transmitted by food handlers to other employees and consumers through contaminated meat food products and careless handling practices.

2.2 It is the responsibility of operators of official establishments to see that no person affected with a disease in a communicable form while a carrier of such disease, or while afflicted with boils, sores, infected wounds, or other abnormal sources of microorganism contamination, works in any area of the establishment where there is likelihood of disease transmision or of meat, poultry, and ingredients becoming contaminated.

2.3 Boils, infected cuts and sore throats are sources of organisms which cause staphylococcal food intoxication, the most frequently reported type of food-borne illness in the United States.

2.4 The operators of meat packing plants are also required to assume the responsibility for prompt reporting to local health authorities, all known or suspect cases of communicable disease among their employees.

3.0 Clothing and Personal Equipment

3.1 All persons handling meat, ingredients, or their contact surfaces must wear clean washable outer garments. Street clothing should not be worn while on duty since it can serve as a source of contamination.

3.2 It is required that all workers change clothing daily. In those jobs where there is routine contact of product with clothing (luggers, e.g.), even more frequent changing may be necessary.

3.3 All employees working in departments where exposed product is handled must wear caps, hats, hair nets, or other effective hair restraints to prevent hair from falling into the product.

3.4 Wearing of loose jewelry should be avoided. Workers are to remove all jewelry that might serve as a source of product contamination during work periods in which foods or components are manipulated by hand.

3.5 Wearing of badges, identification cards, campaign buttons, and similar articles on outer clothing by persons who handle products should be discouraged. However, similar articles necessarily worn must be attached so that their accidental inclusion in product is definitely precluded.

3.6 Boners' aprons, wrist guards, and the like used as safety devices for employees engaged in slaughter, cutting or boning operations must be of impervious construction and maintained in a clean and sanitary manner.

3.7 To assist in maintaining leather boners' aprons in satisfactory condition, a clean, washable cloth covering should be worn over the apron. Use of boners' aprons made of plastic is preferred and encouraged. The cloth covering may then be omitted.

3.8 Employees are required to remove all aprons knives, hooks, and other hand tools before entering toilet rooms.

3.9 Cotton gloves, frequently worn by boners, luggers and others may pose contamination problems. Such gloves can be used only in those operations involving inspected and passed products.

3.10 In order to assure thorough cleaning, all such gloves are to be laundered in a commercial or establishment laundry. Workers using cotton gloves must begin each workday with a clean pair and make periodic changes throughout the day as necessary. At no time should such use exceed four hours per pair (changing is necessitated due to the accumulations of moisture and contaminants coupled with the worker's body temperature which can lead to a rapid buildup of microorganisms).

3.11 Other types of rubber or plastic gloves are commonly worn by various meat handlers. Whatever the type of gloves being used, they should be a light color (not black) so that a ready evaluation of cleanliness and condition may be made. Replacement of such gloves is necessary whenever peeling or other deterioration is observed.

3.12 Protective mesh gloves, while not desirable, may be permitted in viscera separation operations and final rail trim jobs if cleaning and sterilization is carried out after obvious contamination. If protective mesh gloves are used by head droppers, bung droppers or eviscerators, they must be covered by intact rubber or plastic gloves.

3.13 Footwear should be appropriate to the operation and, in most instances, be of waterproof construction or treated to repel water. Since footwear can be a source of transporting contamination, care should be taken to see that all personnel effectively clean their shoes or boots periodically. This is particularly important when one enters an area less contaminated than the one he is leaving, such as an employee going from the kill floor to boning cooler.

CHAPTER 31

WELFARE FACILITIES

1.0 Introduction

1.1 Employee welfare facilities include eating areas, locker rooms, showers, toilets, and hand washing facilities. There is a definite inspection responsibility to see that adequate welfare facilities are provided by plant management. The sanitation of employee welfare facilities should be maintained at the highest possible standards.

1.2 While welfare and comfort of plant workers are of importance, the basic inspectional interest is to obtain the best possible personal hygiene of the plant workers and the prevention of contamination of product with human wastes.

1.3 In addition to vital public health considerations, maintenance of clean, well-lighted, well-ventilated, orderly, and rodent, insect and odor free quarters are also important in that it sets the example to employees of what must be maintained in sanitary, efficient and properly functioning product departments.

2.0 Dressing Rooms and Lockers

2.1 Well located dressing rooms, properly separated from toilet rooms are required for employees. Separate facilities must be provided for each sex unless only one sex is employed at the plant.

2.2 Dressing rooms must be supplied with abundant light and good ventilation. Ventilation exhaust should be to the outside and care taken to see that the air flow is away from product areas.

2.3 Lockers supplied for employees should be of suitable metal or other approved construction. They can either be free standing or built-in school type lockers.

2.4 To permit cleaning beneath the free standing lockers, they must be on legs or other supports about 16 inches high. These lockers shall have sloping tops at sufficient pitch to prevent top storage of clothing and other items.

2.5 It is necessary for built-in lockers to have a positive mechanical ventilation system included as part of the installation and maintained in effective working order. Ventilation of free standing lockers must be provided by doors having lowered openings of adequate size or doors constructed of expanded metal or heavy wire mesh.

2.6 To avoid harborage for insects, back-to-back lockers should be separated by a single back partition in common. Those lockers placed against the wall should have their backs eliminated so the wall serves as the back of the locker.

2.7 To facilitate orderliness and cleaning of the dressing room, employee seats should be in the form of plastic, wood or other suitable planks about 12 inches wide, mounted in front of and below the doors of the lockers on an extension of the framework supporting the lockers.

2.8 If seats not attached to the lockers are preferred, they must be in the form described above and securely fastened by means of a minimum number of pipe leg supports to the floor in the aisle between the lockers.

2.9 The aisle width between rows of lockers shall be about 7 feet minimum when attached seats are used (5 feet between rows of seats) and about 6 feet minimum with centrally located seats.

2.10 To avoid developing objectionable odors and attracting insects and vermin, all clothing, footwear, personal equipment and the like stored in lockers should be clean and dry. Footwear of all kinds should be stored in lockers or on elevated racks or shelves off the floor and never put away in an unclean condition.

2.11 Adequate numbers of appropriately located receptacles must be provided for dirty clothing and trash. An adequate, regular schedule of janitorial service is important in addition to the daily post-operations clean-up.

2.12 A plan for routine locker inspection, at least monthly, is imperative. Since many employees routinely keep their lockers locked, a schedule must be established so all lockers are left unlocked for the inspection.

2.13 It is recommended that a responsible plant representative take part in the locker inspections so that defects can be pointed out and the security of locker contents assured.

2.14 The locker inspection tour should also be utilized to determine if there is an adequate number of lockers and that those in use are in good repair. Lockers needing repair or replacement should be identified to the plant representative and corrective action established. The date, findings, action taken and other pertinent information relating to locker inspections are to be recorded on Form MP-455.

3.0 Shower-bath Facilities

3.1 Suitable shower-bath facilities should be provided in locker rooms (not in toilet rooms) at establishments where slaughtering operations are conducted. Such facilities may also be desirable in processing plants.

UNITED STATES DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
WASHINGTON, D.C.

CHANGE TRANSMITTAL SHEET

☒ DIRECTIVE
☐ REVISION
☐ AMENDMENT
☐ OTHER

SIS DIRECTIVE
EDERAL FACILITIES REQUIREMENTS FOR SMALL EXISTING
EAT PLANTS

11,100.2

3-7-86

. PURPOSE

his document transmits FSIS Directive 11,100.2 and provides instructions to users egarding the filing of the directive.

I. INSTRUCTIONS

he attached directive cover sheet should be filed with FSIS Directives and, if possible, he cover sheet should be attached to the referenced handbook when filed.

II. CANCELLATIONS

his change transmittal is cancelled when the directive is filed. For recordkeeping urposes, users may either retain or destroy this transmittal sheet.

Deputy Administrator
Meat and Poultry Inspection Operations

Attachment
FSIS Directive 11,100.2

DISTRIBUTION: All MPI Offices, T/A Inspectors, Plant Management, T/A Plant Management, Science and Compliance Offices, Import Offices, R&E, TRA, ABB

OPI: MPITS/FESD

UNITED STATES DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
WASHINGTON, D.C.

FSIS DIRECTIVE

11,100.2 | 3-7-86

FEDERAL FACILITIES REQUIREMENTS FOR SMALL EXISTING MEAT PLANTS HANDBOOK

I. PURPOSE

This directive incorporates the subject handbook into the FSIS Issuance System.

II. RESERVED

III. RESERVED

IV. REFERENCE

FSIS Directive 11,100.1

V. POLICY

In January 1984, FSIS established a unified comprehensive system for the issuance of all standing instructions implementing the Agency's policies and procedures in the form of FSIS Directives. Directives are assigned a number according to subject classification as found in Attachment 2, FSIS Directive 2610.1, Revision 3, dated 11/25/85.

In keeping with the goal of providing a single, unified system for all materials that provide direction to personnel, Agency handbooks will be designated as directives and incorporated into the new system. Therefore, this directive cover sheet is issued and should be attached to the handbook, and filed with other FSIS Directives.

Deputy Administrator
Meat and Poultry Inspection Operations

DISTRIBUTION: All MPI Offices, T/A Inspectors Plant Management, T/A Plant Management, Science and Compliance Offices, Import Offices, R&E, TRA, ABB

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